

# *Grizzly* *Industrial, Inc.*®

## 12" HORIZONTAL RESAW BANDSAW MODEL G0503 INSTRUCTION MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
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(FOR MODELS MANUFACTURED SINCE 12/08) #EW6190 PRINTED IN TAIWAN



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.**

**Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.**

**The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.**

**The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.**



## **WARNING!**

**Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:**

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

**Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.**

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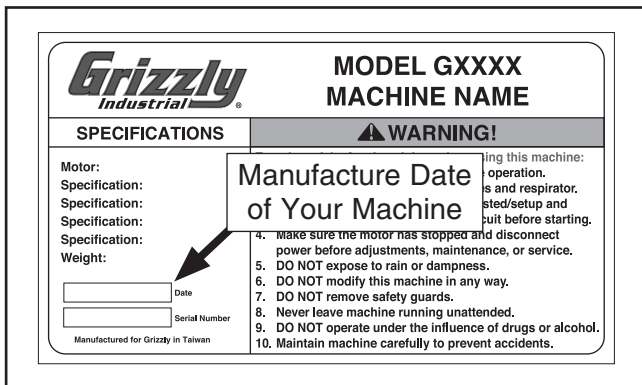
# INTRODUCTION

## Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at [www.grizzly.com](http://www.grizzly.com). Any updates to your model of machine will be reflected in these documents as soon as they are complete.

## Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Email: [techsupport@grizzly.com](mailto:techsupport@grizzly.com)

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: [manuals@grizzly.com](mailto:manuals@grizzly.com)

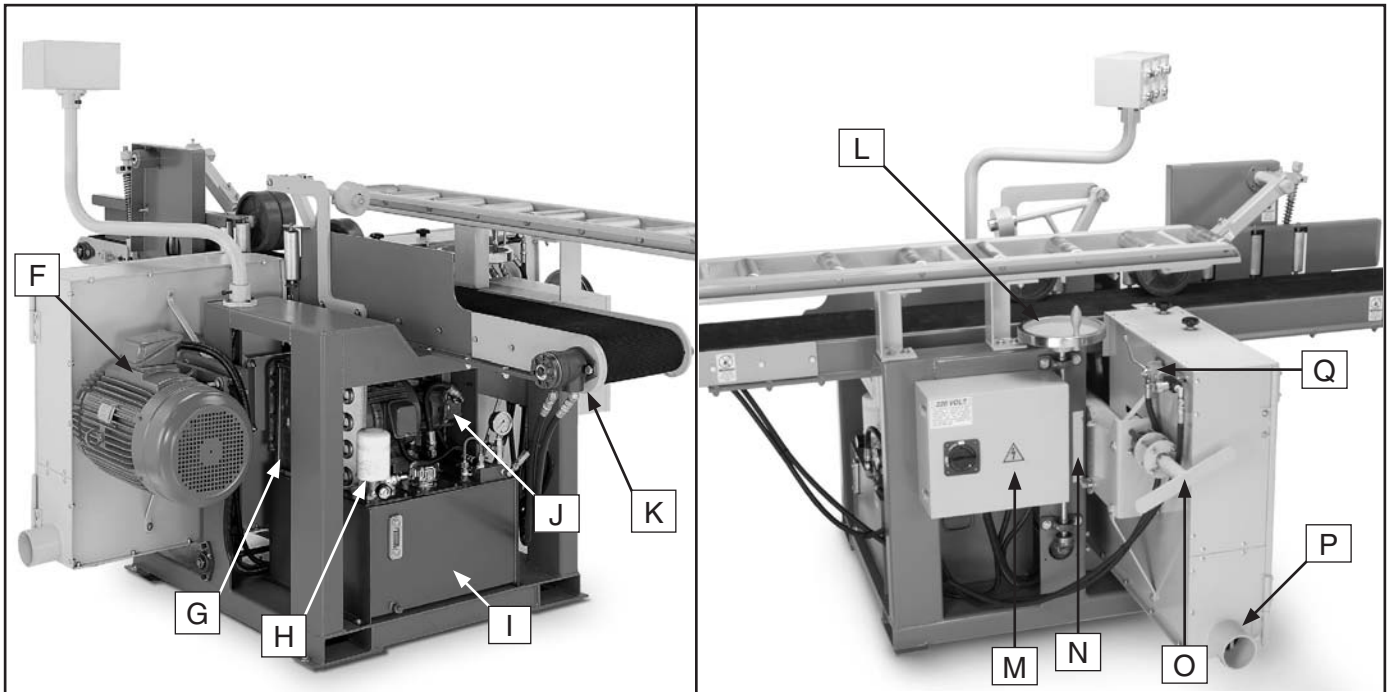


**Figure 1.** Main view of machine features and controls.

## Identification

- A. Infeed Pressure Rollers**—Maintain downward pressure on the board to keep it steady during cutting.
- B. Return Rollers**—Allows the person receiving the newly cut board to return it to the operator without walking around the saw.

- C. Infeed Conveyor**—Moves the board through the bandsaw blade during cutting.
- D. Control Panel**—Controls power to the main motor and the hydraulic motor. For more details, see **page 6**.
- E. 4" Dust Port**—Allows the resaw to be connected to a dust collection system.



**Figure 2.** Back and side views of machine features and controls.

- F. Main Motor**—Drives the saw wheels for blade movement and drives the hydraulic pump for conveyor movement.
- G. Hydraulic System Oil Cooler**—Cools the hydraulic fluid for the hydraulic system.
- H. Hydraulic Fluid Filter**—Removes contaminating particles from the hydraulic fluid.
- I. Hydraulic Tank**—Holds and cools the hydraulic fluid.
- J. Hydraulic Pump**—Creates hydraulic oil flow which drives the conveyor motor.
- K. Hydraulic Conveyor Motor**—Utilizes the hydraulic fluid flow from the hydraulic pump drive motor to move the conveyor belt.
- L. Head Elevation Handwheel**—Moves the head (the part of the saw that contains the wheels and blade) up or down as needed.
- M. Electrical Control Box**—Main area for wiring, rewiring, and changing the fuses. Should never be opened when the machine is connected to the power source!
- N. Blade Elevation Gauge**—Shows the blade height.
- O. Blade Tensioner**—Provides a mechanical means for properly tightening the blade.
- P. 4" Dust Port**—Connection point for a dust collection system.
- Q. Conveyor Belt Controls**—Controls ON/OFF and conveyor speed.

# Control Panel

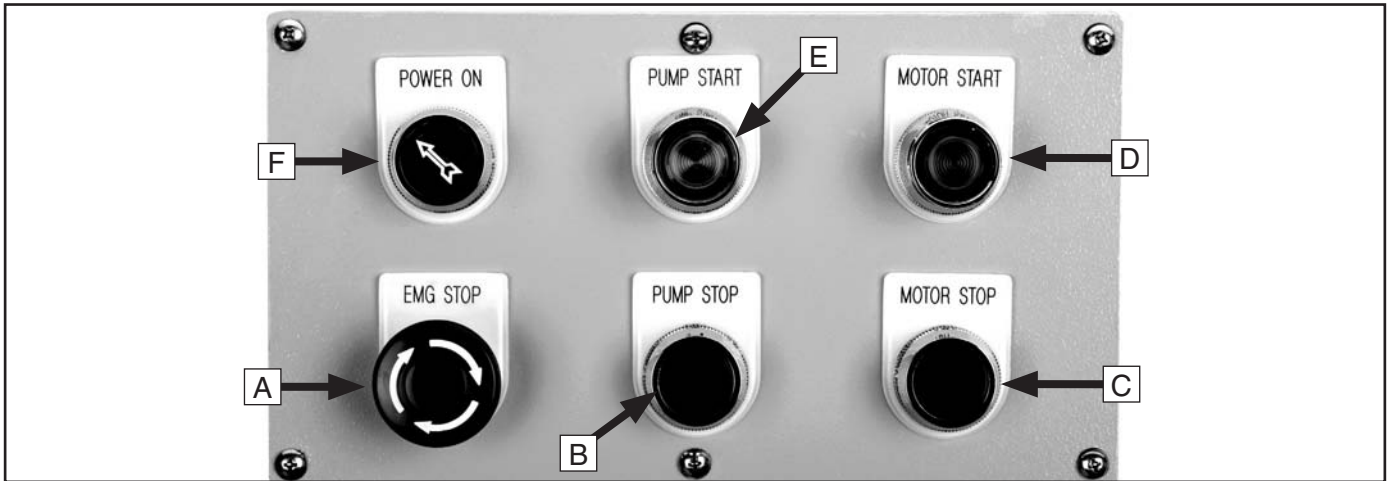


Figure 3. Control panel close-up.

- A. **EMERGENCY STOP Button**—Turns off power to both motors in an emergency.
- B. **PUMP STOP Button**—Stops the hydraulic pump motor.
- C. **MOTOR STOP Button**—Stops the main motor.
- D. **MOTOR START Button**—Starts the main motor and the saw blade.
- E. **PUMP START Button**—Starts the hydraulic pump motor.
- F. **POWER ON Button**—Connects power to both motors.







# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

## MODEL G0503 12" Horizontal Resaw Bandsaw

Design Type ..... Horizontal Floor Model

### Overall Dimensions:

Conveyor Table ..... 12"W x 107"D  
 Height From Floor To Table ..... 35<sup>3</sup>/<sub>4</sub>"  
 Height From Floor To Back Roller ..... 46<sup>3</sup>/<sub>4</sub>"  
 Overall Height ..... 65<sup>1</sup>/<sub>2</sub>"  
 Overall Width ..... 81"  
 Overall Depth ..... 108"  
 Shipping Weight (Both Crates) ..... 1980 lbs.  
 Machine Weight ..... 1870 lbs.  
 Crate 1 Size ..... 83"L x 51"W x 38"H  
 Crate 2 Size ..... 118"L x 43"W x 25"H  
 Footprint ..... 40"W x 39<sup>1</sup>/<sub>4</sub>"L

### Capacities:

Maximum Workpiece Size ..... 12" x 12"  
 Maximum Distance From Blade to Conveyor Table ..... 6"  
 Saw Wheel Diameter ..... 28"H x 7<sup>7</sup>/<sub>8</sub>"W  
 Saw Blade Size ..... 168"L x 1"W x .035"Thickness  
 Saw Blade Speed ..... 7000 FPM

### Construction:

Frame ..... Steel  
 Conveyor Table ..... Steel  
 Conveyor Belt ..... Rubber  
 Wheels ..... Steel  
 Wheel Cover..... Pre-Formed Steel  
 Guides ..... Carbide Guide  
 Pressure Roller ..... 8" Cast Iron w/Polyurethane Tire

### Main Motor:

Type ..... TEFC Induction  
 Horsepower ..... 20 HP  
 Phase / Voltage ..... Three-Phase / 220V/440V, Prewired 220V  
 Amps ..... 48/24A  
 Cycle / RPM..... 60 Hertz / 1725 RPM  
 Switch ..... 220V Magnetic w/Thermal Overload Protector  
 Bearings ..... Shielded & Lubricated Ball Bearings

### Hydraulic Motor:

Type ..... TEFC Induction  
 Horsepower ..... 2 HP  
 Phase / Voltage ..... Three-Phase / 220V/440V, Prewired 220V  
 Amps ..... 6/3A  
 Cycle / RPM..... 60 Hertz / 1720 RPM  
 Hydraulic Pressure ..... 775 PSI (55 KG/CM2)

### Features:

..... Three 4" Dust Ports  
 ..... Return Rollers  
 ..... Manual Saw Wheel Elevation  
 ..... Variable Speed Hydraulic Feed Conveyor  
 ..... Quick Adjust Blade Tension Handle

*Specifications, while deemed accurate, are not guaranteed.*

# SECTION 1: SAFETY


## WARNING

### For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

 **DANGER** Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

 **WARNING** Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

**NOTICE** This symbol is used to alert the user to useful information about proper operation of the machine.

## WARNING

### Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

# WARNING

## Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in **OFF** position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning *ON* machinery.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to be ejected.
24. **ALWAYS LOCK MOBILE BASES BEFORE OPERATING MACHINERY.**

# WARNING

## Additional Safety Instructions for Resaws

- 1. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Service Department at (570) 546-9663.
- 2. ENTANGLEMENT.** Keep loose clothing and long hair away from moving conveyors! Roll up or button sleeves at the cuff.
- 3. HAND PLACEMENT.** Do not allow fingers to be pinched between board and conveyor belt during operation. This may pull the operator's hand into the machine and cause serious injury or death!
- 4. GUARDS.** Do not operate this bandsaw without wheel guards, pulley guards, and blade guards in place.
- 5. POWER DISCONNECT.** Do all inspections, adjustments, and maintenance with the power *OFF* and the circuit breaker shut off. Wait for all moving parts to come to a complete stop.
- 6. DULL BLADES.** Do not operate with dull or badly worn blades. Dull blades place more demand on the motor and are less likely to cut precisely. Inspect blades before each use.
- 7. BLADE REPLACEMENT.** Make sure the teeth face toward the front of the saw when replacing blades.
- 8. BLADE TENSION.** Make sure blade is properly tensioned before operating machine.
- 9. BLADE SPEED.** Blade should be running at full speed before beginning a cut.
- 10. CONVEYOR SPEED.** Always feed stock evenly and smoothly. **DO NOT** change conveyor speeds during a cut.
- 11. MATERIAL SPECIFICATIONS.** This machine is not designed to cut metal or any other material besides wood.
- 12. WORKPIECE SUPPORT.** Cuts should always be fully supported against the guide rollers and by the pressure rollers.
- 13. WORKPIECE DIRECTION.** Do not back workpiece away from the blade while the saw is running. If you need to back the work out, stop the bandsaw and wait for the blade to stop. **DO NOT** twist or put excessive stress on blade while backing work away.
- 14. STOPPING THE BLADE.** Do not manually stop or slow blade after turning the saw *OFF*.
- 15. UNATTENDED MACHINE.** Allow the resaw to come to a complete stop before leaving it unattended.

### WARNING

Like all machines there is danger associated with the Model G0503. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

### CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

# WARNING

## Additional Safety Instructions for Hydraulics

1. **HYDRAULIC INJECTION HAZARDS.** Be familiar with the hazards of hydraulic injection injuries.
  - Leaking hydraulic fluid may have enough pressure to penetrate skin. Never use your hands to check for suspected hydraulic leaks.
  - Hydraulic fluid that is injected into skin is a medical emergency that may cause infection, disability, amputation or death.
  - The average injection injury may be a small wound that has barely broken the skin. **DO NOT** be fooled by this type of injury. Immediately get to an emergency medical facility!
  - Minimizing the time between the injury and when the injected material is removed is critical to minimizing the seriousness of the injury.
2. **EYE PROTECTION.** Safety glasses may not always protect your eyes from hot, pressurized fluid. The best way to protect yourself is to stay away from leaks until you can depressurize the system.
3. **HYDRAULIC LEAKS.** Stop the machine if you notice a hydraulic leak. Allowing the machine to continue running with a leak may increase the hazard of the situation and damage the machine.
4. **CHECKING FOR LEAKS.** Use a piece of cardboard to check for suspected hydraulic leaks. Pressurized hydraulic fluid may cause injection injuries and can be extremely hot. Never use your hands to check for suspected hydraulic leaks.
5. **DEPRESSURIZE FOR MAINTENANCE.** Depressurize the hydraulic system before attempting any maintenance or service. Stop the resaw, open the conveyor speed valves, and make sure the pressure gauge reads 0 PSI.
6. **INSPECTIONS.** Regularly inspect and perform maintenance on the hydraulic system. A well-maintained hydraulic system will have much fewer problems and hazards than a neglected system.
7. **CLEAN MAINTENANCE AREA.** Make sure any hydraulic system maintenance is performed in a clean and dust-free work area. Remove any sawdust, grime or water from hydraulic system openings or components before maintenance. Always use lint-free rags when wiping components.
8. **COMPONENT REPLACEMENT.** Only use high pressure hydraulic hose and steel hydraulic fittings when replacing components in the hydraulic system. **DO NOT** use brass or aluminum.

# SECTION 2: CIRCUIT REQUIREMENTS

## 220V 3-Phase

### **WARNING**

Serious personal injury could occur if you connect your machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

#### **Wiring**

The Model G0503 is prewired for 220V 3-phase operation.

#### **Amperage Draw**

The Model G0503 has a 20 HP main motor and a 2 HP hydraulic pump motor that will draw the following amps at 220V 3-phase:

Main Motor ..... 48 Amps  
Hydraulic Pump Motor ..... 6 Amps

#### **Circuit Breaker Requirements**

Install the machine on a dedicated circuit to reduce the possibility of overloading the circuit and tripping the circuit breaker. If the circuit breaker trips and the circuit is of the correct load capacity, have the circuit inspected by a qualified electrician. Never use a larger circuit breaker than stated below, or you will increase the risk of fire.

Circuit Breaker ..... 60 Amp

#### **Minimum Wire Requirements**

For 220V 3-phase operation, use the following type of wire:

Wire ..... 6 GA. Copper

We recommend running THWN/THHN grade insulated wire through rigid conduit and hardwiring into a locking power disconnect. Consult a qualified electrician for information on local and national electrical codes.

## 440V 3-Phase

### **WARNING**

Serious personal injury could occur if you connect your machine to the power source before you have completed the setup process. **DO NOT** connect the machine to the power source until instructed to do so.

#### **Wiring**

The Model G0503 is prewired for 220V 3-phase operation. If 440 voltage is required, rewire the machine per the instructions on **page 49**, and follow the circuit requirements on this page.

#### **Amperage Draw**

The Model G0503 has a 20 HP main motor and a 2 HP hydraulic pump motor that will draw the following amps at 440V 3-phase:

Main Motor ..... 24 Amps  
Hydraulic Pump Motor ..... 3 Amps

#### **Circuit Breaker Requirements**

Install the machine on a dedicated circuit to reduce the possibility of overloading the circuit and tripping the circuit breaker. If the circuit breaker trips and the circuit is of the correct load capacity, have the circuit inspected by a qualified electrician. Never use a larger circuit breaker than stated below, or you will increase the risk of fire.

Circuit Breaker ..... 30 Amp

#### **Minimum Wire Requirements**

For 440V 3-phase operation, use the following type of wire:

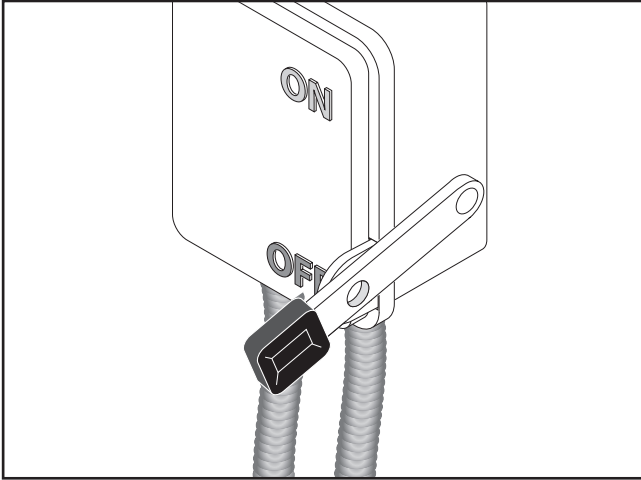
Wire ..... 10 GA. Copper

We recommend running THWN/THHN grade insulated wire through rigid conduit and hardwiring into a locking power disconnect. Consult a licensed electrician for information on local and national electrical codes.



## Connection Type

Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking shut-off lever (see **Figure 4**) near the machine as a way to quickly disconnect the power and prevent accidental starting. We **DO NOT** recommend using an extension cord with this machine.



**Figure 4.** A power disconnect is preferable to high current plugs and receptacles.

## Your Shop Circuit Capacity

Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.



## Phase Converter

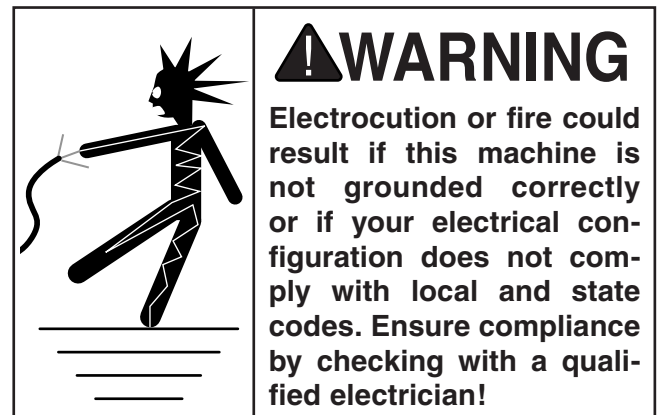
When using a phase converter, the power from the manufactured power leg (sometimes called the wild wire) can fluctuate. Connect the manufactured power leg to the S terminal to prevent damage to the transformer. The wire from the S terminal can handle some fluctuation because it goes directly to the motor. The power going to the R and T terminals goes to the transformer and must be consistent to prevent damage.



# Grounding

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This machine must be equipped with an electric cord that has an equipment grounding conductor. This conductor must be grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor increases the risk of electric shock. Check with a qualified electrician or one of our service personnel if you do not understand the grounding instructions, or if you doubt the machine is properly grounded.



## Extension Cords

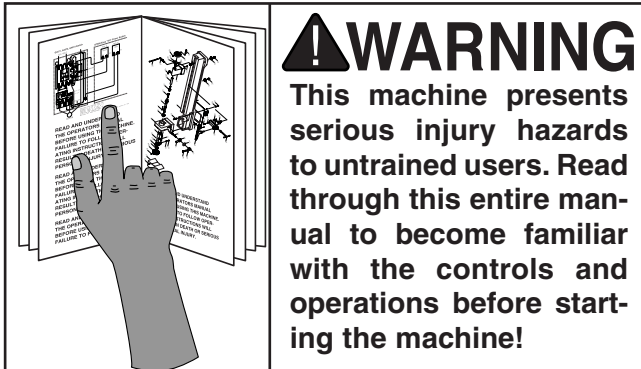
Because of the high amperage draw from this machine, we do not recommend the use of extension cords. Instead, position your equipment near installed wiring to eliminate the need for extension cords.



# SECTION 3: SET UP

## About this Section

The purpose of this section is to guide you through the required steps to get your machine out of its crate and into operating condition.



## Unpacking

The Model G0503 left our warehouse in a carefully built crate. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the equipment from the shipping crate.



## Piece Inventory

### The inventory of the shipping crate includes:

- Resaw..... 1
- Bandsaw Blade 168" x 1" x 0.035"..... 1
- Handwheel Handle..... 1
- Blade Cover..... 1
- Tool Box..... 1
- Wrench Set—10, 12, 13, 14, 17, 19, 21mm... 1
- Hex Wrench Set—2.5, 3, 4, 5, 6, 8, 10mm .. 1
- Open End Wrench—35mm..... 1
- T-Handle Wrench ..... 1
- Phillips Head Screwdriver..... 1
- Flat Head Screwdriver ..... 1
- Pry Tool ..... 1
- Bolt Bag
  - Carriage Bolt M10-1.5 x 30 ..... 6
  - Flat Washer 10MM ..... 6
  - Lock Nut M10-1.5..... 6
  - Carriage Bolt M6-1.0 x 16..... 4
  - Flat Washer 6MM ..... 4
  - Lock Nut M6-1.0..... 4

In the event that any non-proprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



Figure 5. Piece inventory.



# Hardware Recognition Chart

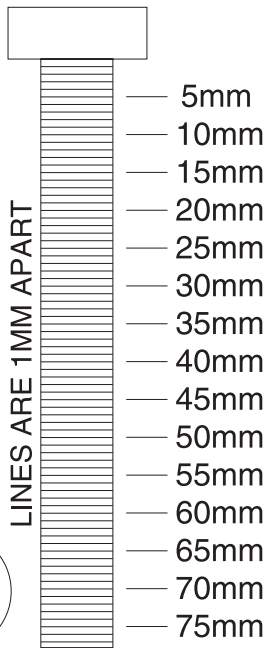
USE THIS CHART TO MATCH UP  
HARDWARE DURING THE ASSEMBLY  
PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

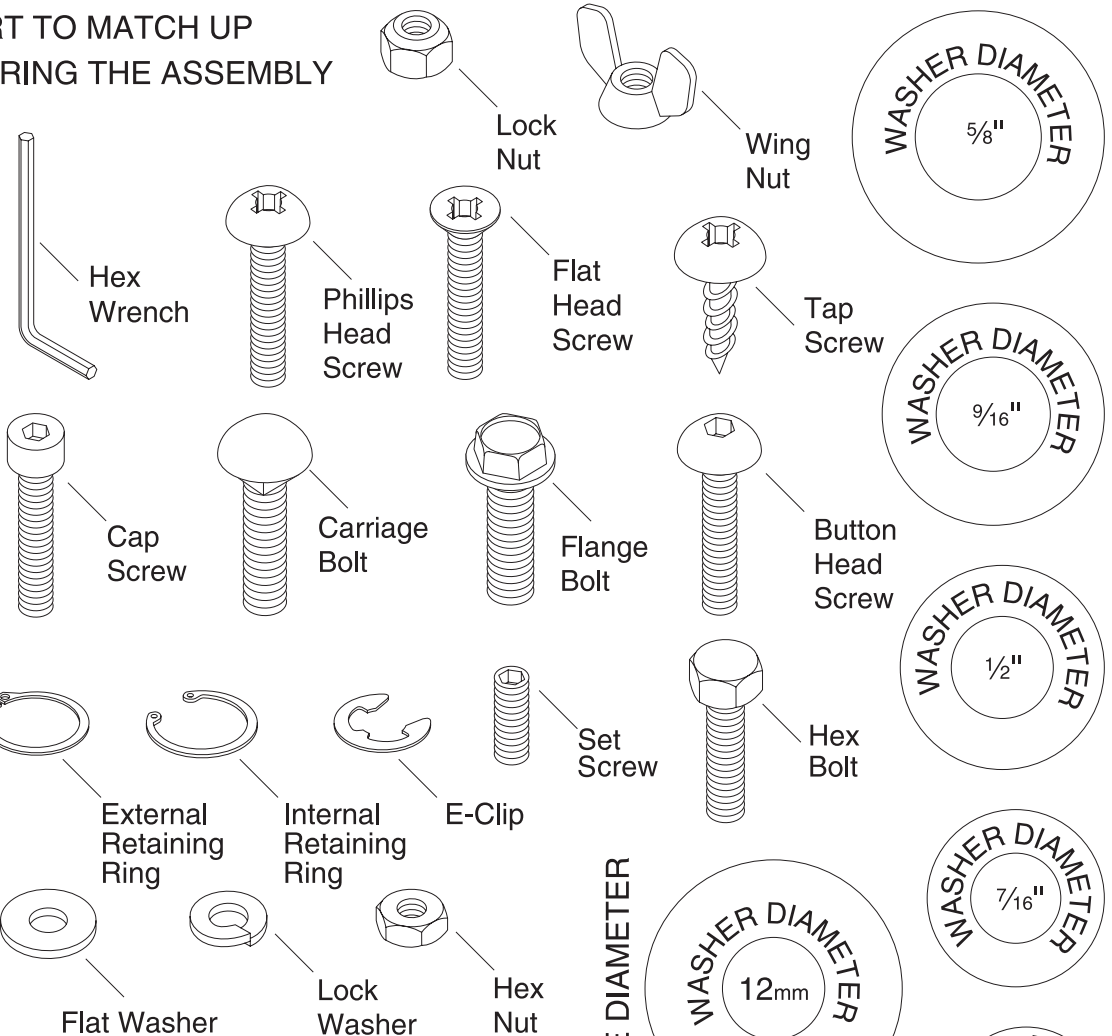
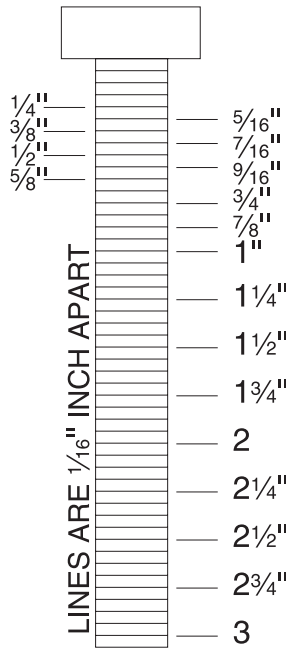
- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"

- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm

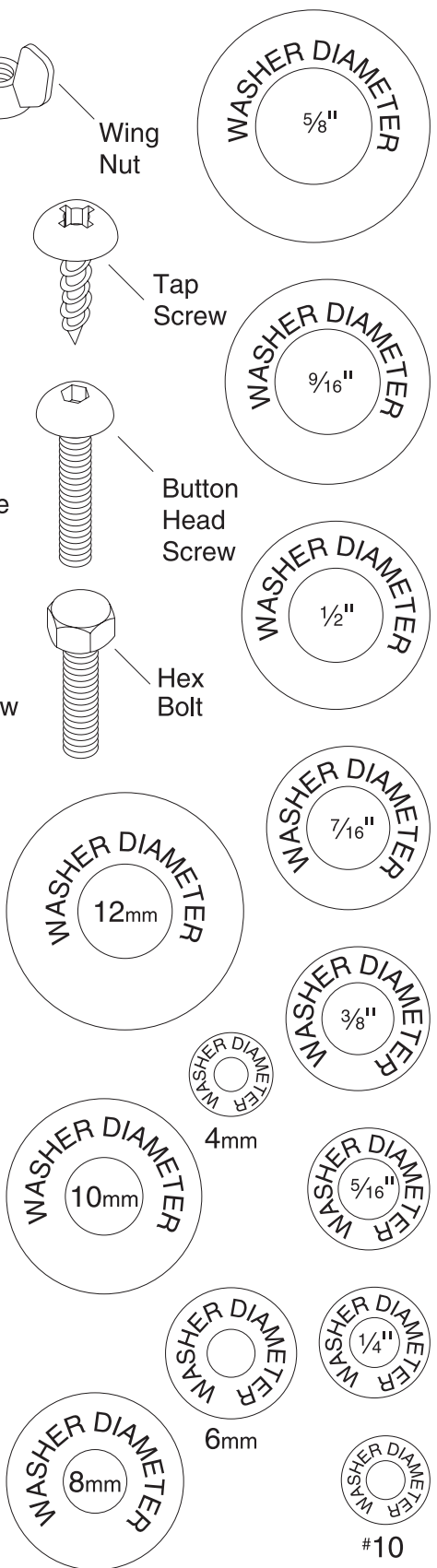
LINES ARE 1MM APART



LINES ARE 1/16" INCH APART



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



# Items Needed for Set Up


| ITEM                                    | QTY         |
|---|-------------|
| Forklift .....                          | 1           |
| Citrus-Based Degreaser or Solvent ..... | Varies      |
| Metal Protectant .....                  | Varies      |
| Hammer Drill .....                      | 1           |
| Air Compressor .....                    | 1           |
| Vacuum .....                            | 1           |
| Punch 1/2" .....                        | 1           |
| Hammer drill bit 1/2" X 6" .....        | 1           |
| Hammer .....                            | 1           |
| Lag Shields 5/16" x 3" .....            | 6           |
| Lag Bolts 5/16" x 4" .....              | 6           |
| Flat Washers 5/16" .....                | 6           |
| Assistants .....                        | 3           |
| Dust Collector (1500 CFM min.) .....    | 1           |
| Dust Collection Hoses 4" .....          | 3           |
| Hose Clamps 4" .....                    | 3           |
| Protective Gloves .....                 | 1 Pair      |
| Locking Power Disconnect Lever .....    | 1           |
| Conduit .....                           | Varies      |
| Conduit Connectors .....                | 2           |
| Power Cord or Wires .....               | See page 12 |



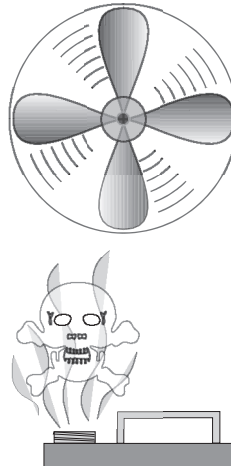
# Clean Up

The wheels and the blade guides of the Model G0503 are coated with a light coat of grease to protect them from corrosion during shipment. Remove the blade guard for complete access to the blade guides and clean off the protective coating with a solvent or citrus-based degreaser such as Grizzly's G7895 Degreaser shown on **page 32**. Avoid chlorine-based solvents, such as acetone or brake cleaners, as they may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

After the wheels and guide block assemblies have been cleaned, coat them liberally with a metal protectant and reinstall the blade guard. For metal protectants, we recommend using G96® GUN TREATMENT or BOESHIELD® T-9 shown on **page 32**.



**! WARNING**  
Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. **DO NOT** use gasoline or petroleum products to clean the machinery.



**! CAUTION**  
Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.



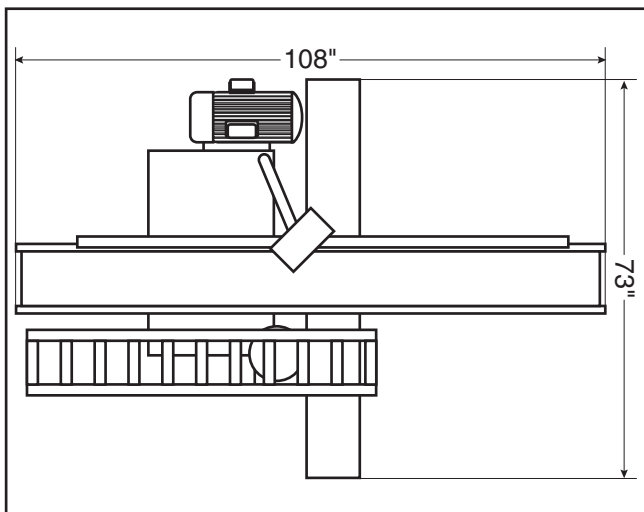
# Site Considerations

## Floor Load

The Model G0503 weighs 1870 lbs. and has a base footprint of 40"W x 39¼"L. The floor where this machine will be installed must be level and structurally sound. Most commercial floors are suitable for your machine. Some floors may require additional reinforcement.

## Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 6** for the minimum working clearances of the Model G0503.



**Figure 6.** Working clearances.

|   |  |
|---|--|
|  | <p><b>! CAUTION</b></p> <p>Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and <b>DO NOT</b> allow unsupervised children or visitors in your shop at any time!</p> |
|---|--|



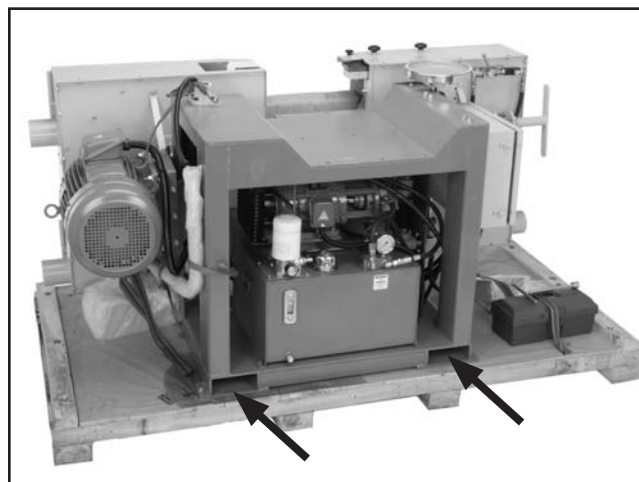
# Removing Resaw from the Crate Pallet

|  |  |
|--|--|
|  | <p><b>! WARNING</b></p> <p>The Model G0503 weighs 1870 lbs. Serious personal injury may occur if not moved safely. You will need assistance and power equipment when moving the shipping crate and removing the machine from the pallet. If you are unsure of how to lift this equipment safely, consult a qualified professional.</p> |
|--|--|

| Tools Needed             | QTY |
|--------------------------|-----|
| Wrench/Socket 14mm ..... | 1   |
| Forklift.....            | 1   |

## To remove the resaw from the crate pallet:

1. Remove the lag bolts from the stand feet that secure the resaw to the crate pallet.
2. Slide the forklift forks into the forklifting points (shown in **Figure 7**), lift the resaw off of the pallet and move it to a permanent location.



**Figure 7.** Forklift lifting points.



# Mounting Resaw to the Floor

We recommend that you bolt your new resaw to the floor. Because this is optional and floor materials may vary, floor mounting hardware is not included. It may be necessary to level the floor before installing this machine.

Note—*The instructions below are given for a typical heavy-duty shop floor made of 6" thick concrete. Also, anchor studs may be substituted for lag bolts, but they will stick out of the floor if you decide to move your machine at a later point.*

| <b>Tools Needed</b>              | <b>Qty</b> |
|----------------------------------|------------|
| Hammer Drill .....               | 1          |
| Punch 1/2" .....                 | 1          |
| Hammer drill bit 1/2" x 6" ..... | 1          |
| Hammer.....                      | 1          |
| Air Compressor .....             | 1          |
| Vacuum .....                     | 1          |

| <b>Hardware Needed</b>       | <b>Qty</b> |
|------------------------------|------------|
| Lag Shields 5/16" x 3" ..... | 6          |
| Lag Bolts 5/16" x 4" .....   | 6          |
| Flat Washer 5/16" .....      | 6          |

## To mount the resaw machine to the floor:

1. Put on safety glasses and a dust mask before starting!
2. Use the mounting holes in the resaw stand feet to act as a guide for drilling into your floor, and drill approximately 3 1/2" deep into the concrete floor.
3. Using compressed air and a vacuum, remove the concrete dust from the newly drilled holes.
4. Using the hammer and punch, pound the lag shields into the concrete below the stand feet and flush with the surface of the concrete.
5. Secure the resaw to the floor with the lag bolts and washers.



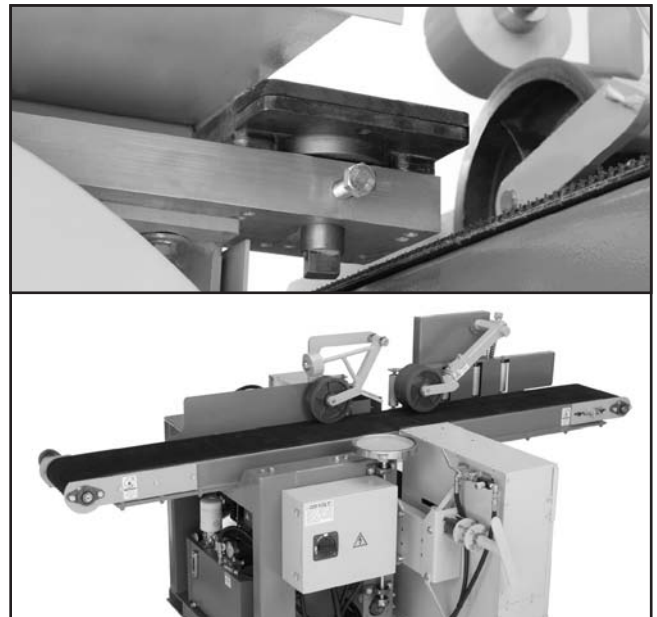
# Mounting the Conveyor Belt

| <b>Tools Needed</b>      | <b>Qty</b> |
|--------------------------|------------|
| Wrench/Socket 17mm ..... | 1          |

| <b>Hardware Needed</b>           | <b>Qty</b> |
|----------------------------------|------------|
| Carriage Bolt M10-1.5 x 30 ..... | 6          |
| Flat Washer 10mm .....           | 6          |
| Lock Nut M10-1.5 .....           | 6          |

## To install the conveyor belt onto the resaw:

1. Remove the lag bolts that secure the conveyor belt assembly to the crate pallet.
2. Remove the blade guide (shown in the upper half of **Figure 8**) from the wheel housing.

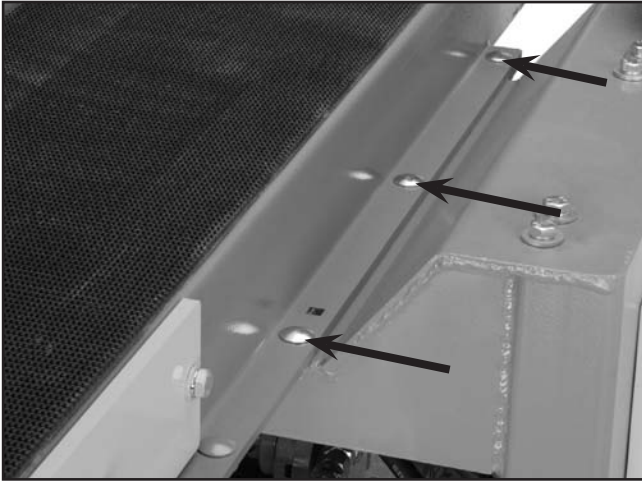


**Figure 8.** Conveyor belt placement.

|  |   |
|--|---|
|  | <p><b>CAUTION</b><br/>The conveyor belt is very heavy. Seek assistance or use power equipment to mount the conveyor belt.</p> |
|--|---|

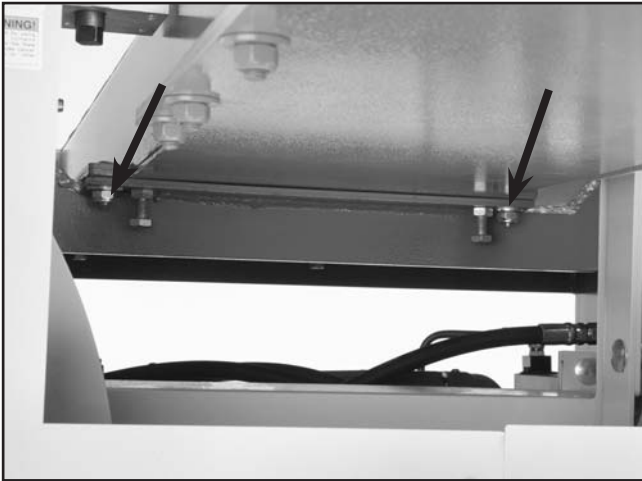
3. Lift the conveyor belt onto the resaw body as shown in the lower half of **Figure 8**.

- Line up the holes and insert the carriage bolts as shown in **Figure 9**.



**Figure 9.** Carriage bolt placement.

- Look under the conveyor for the carriage bolts shown in **Figure 10**. Place the flat washers and lock nuts on the carriage bolts and tighten.



**Figure 10.** Conveyor washer/nut placement.

- Re-install the blade guard in the wheel housing.



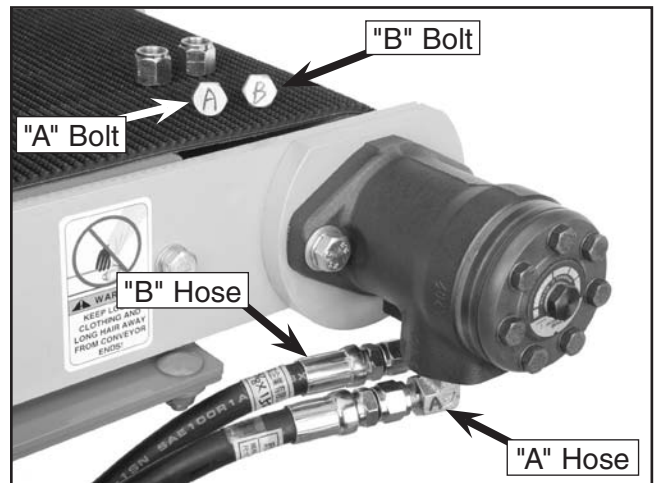
## Attaching the Hydraulics

| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 19mm ..... | 1   |
| Wrench/Socket 17mm ..... | 1   |

The hydraulic hoses and fittings are capped for protection during shipping and labeled with an "A" or a "B" for ease of assembly.

### To attach the hydraulic drive to the conveyor:

- Remove the bolt labeled "B" from elbow fitting in the hydraulic drive motor.
- Remove the cap from the hose labeled "B".
- Thread the "B" hose into the elbow fitting as shown in **Figure 11** and tighten.



**Figure 11.** Connecting the hydraulics.

- Repeat **Steps 1–3** for the "A" elbow fitting and hose.





# Installing the Blade Cover

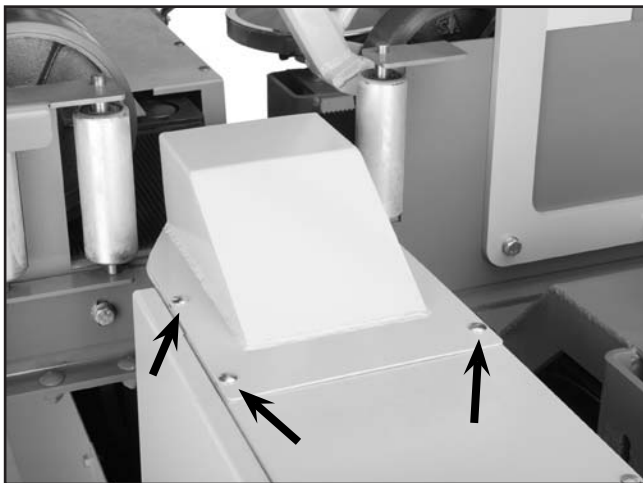
---

| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 10mm ..... | 1   |

| Hardware Needed                | Qty |
|--------------------------------|-----|
| Carriage Bolt M6-1.0 x 16..... | 4   |
| Flat Washer 6mm.....           | 4   |
| Lock Nut M6-1.0 .....          | 4   |

## To attach the blade cover:

1. Line up the holes in the blade cover with the holes in the blade housing.
2. Drop the carriage bolts into the holes indicated in **Figure 12**.



**Figure 12.** The blade cover.

3. Open the wheel cover to access the carriage bolts.
4. Place the washers and lock nuts on the carriage bolts and tighten.



# Attaching the Handwheel Handle

---

| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 19mm ..... | 1   |

| Hardware Needed       | Qty |
|-----------------------|-----|
| Handwheel Handle..... | 1   |

## To attach the handwheel handle:

1. Remove the nut and washer from the handwheel handle.
2. Slide the handle shaft through the hole in the head elevation handwheel.
3. Place the lock washer on the shaft and thread on the nut.
4. Hold the handle stationary and tighten the nut with the 19mm wrench.



**Figure 13.** Head elevation handwheel.

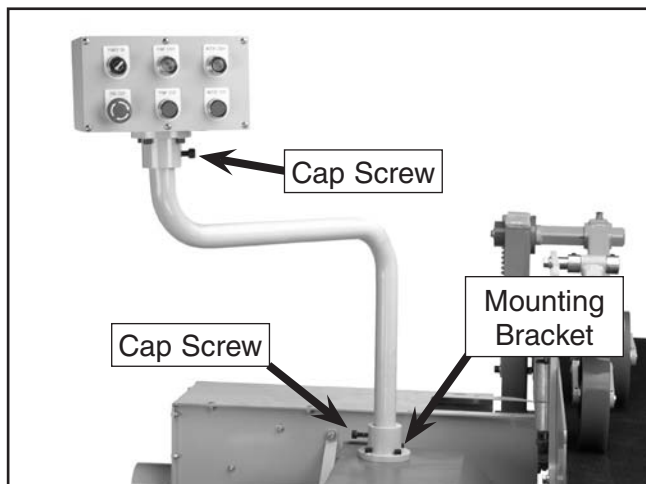


# Positioning the Control Panel

| Tools Needed         | Qty |
|----------------------|-----|
| Hex Wrench 8mm ..... | 1   |

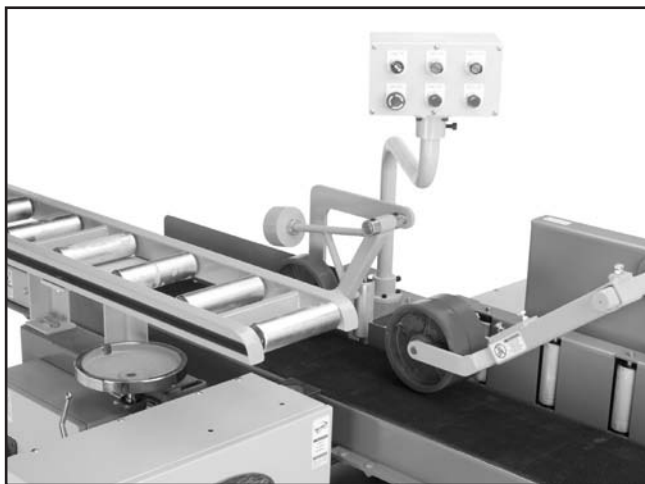
## To mount the control panel:

1. Unwrap the protective covering from the control panel and support arm.
2. Place the control panel support arm into the mounting bracket as shown in **Figure 14**.



**Figure 14.** Control panel assembly.

3. Position the control panel for easy access, as shown in **Figure 15**, and tighten the cap screws shown in **Figure 14**.



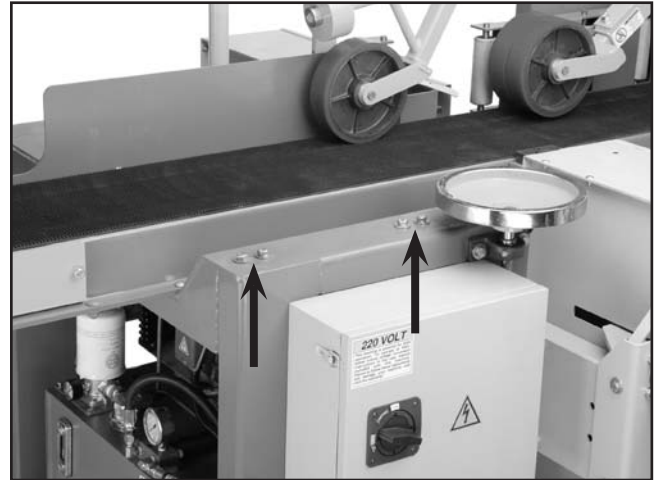
**Figure 15.** Control panel positioning.

# Mounting the Return Rollers

| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 17mm ..... | 1   |

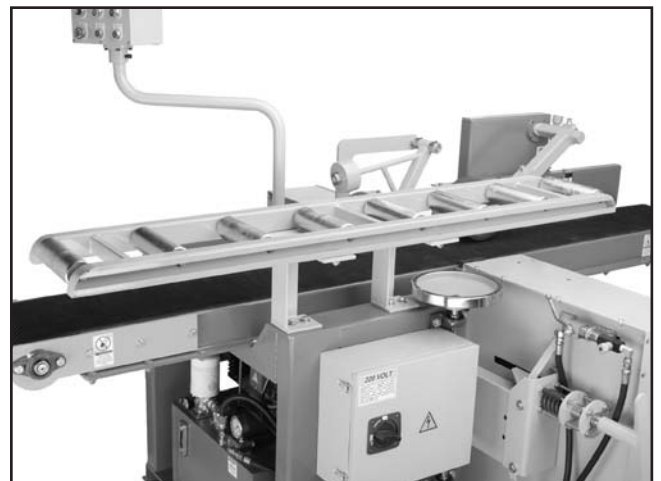
## To mount the return rollers:

1. Remove all four bolts shown in **Figure 16**.



**Figure 16.** Return roller mounting bolts.

2. Get assistance and lift the rollers into the position shown in **Figure 17**.
3. Thread the bolts with washers through the return roller holes and into the resaw.



**Figure 17.** Return roller placement.



# Connecting to the Dust Collector

To be effective, the dust collection system that you connect to the resaw must be able draw a minimum of 1500 CFM at the point where you connect the hoses to the resaw. Note—*This number is an approximation and has been provided for estimation purposes only.*

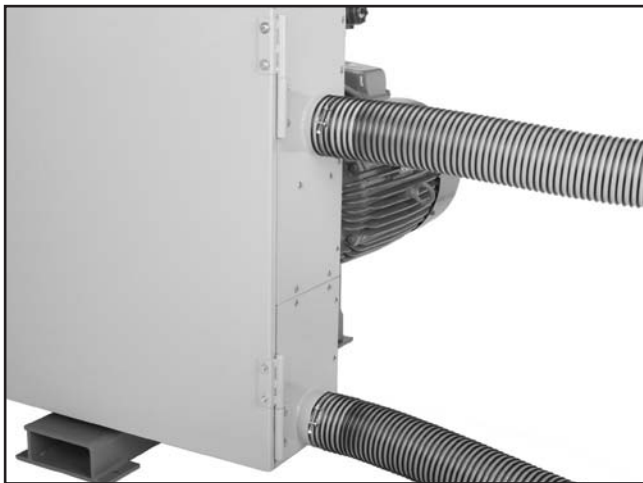
| <b>Tools Needed</b>             | <b>Qty</b> |
|---------------------------------|------------|
| Phillips Head Screwdriver ..... | 1          |

| <b>Hardware Needed</b>         | <b>Qty</b> |
|--------------------------------|------------|
| Dust Collection Hoses 4" ..... | 3          |
| Hose Clamps.....               | 6          |
| Dust Collector.....            | 1          |

## To connect the resaw to a dust collector:

1. Attach a 4" dust hose to all three dust ports as shown in **Figure 18**, and be sure to tighten the hose clamp to ensure a snug fit.



**Figure 18.** Dust hoses connected to dust ports.

2. Attach all three dust hoses to a dust collection system with hose clamps.



# Installing the Blade

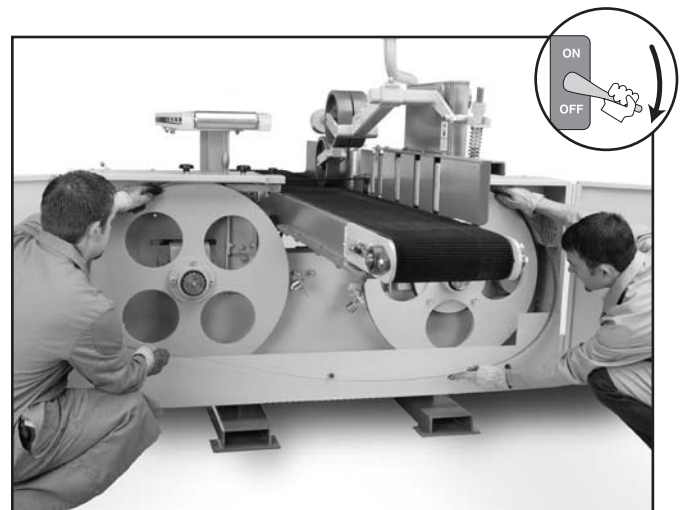
|  |  |
|--|--|
|  | <p><b>!WARNING</b><br/>           These instructions present a serious injury hazard if done while the machine is connected to power. <b>DO NOT</b> connect to power until instructed!</p> |
|--|--|

Blade installation can be done by one person but is easiest if done with two people.

| <b>Hardware Needed</b> | <b>Qty</b> |
|------------------------|------------|
| Resaw Blade .....      | 1          |

## To install the blade:

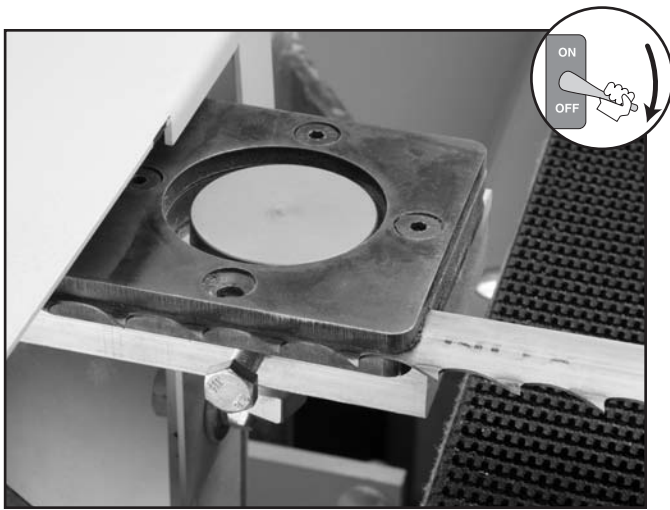
1. **Disconnect the resaw from the power source!**
2. Put on protective gloves.
3. Open the wheel covers for access to the wheels.
4. Hold the blade from each side, and position it in front of the wheels so the blade teeth are facing the front of the machine, as shown in **Figure 19**.



**Figure 19.** Positioning blade for installation.

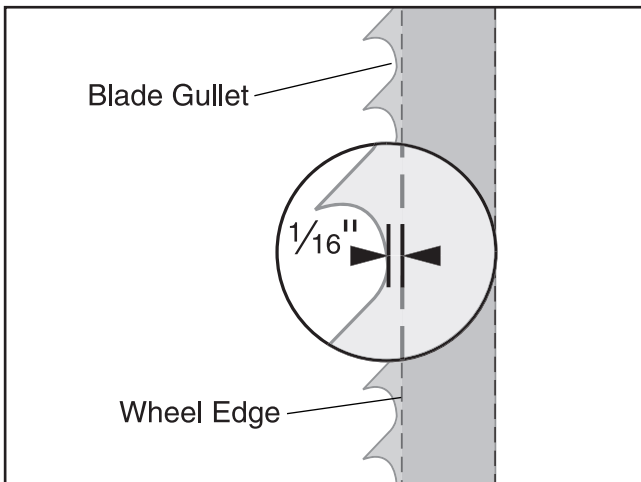


- Carefully fit the blade over each wheel, and position it between the blade guides as shown in **Figure 20**. Make sure the teeth point toward the right-hand side of the machine, as you are facing the front.



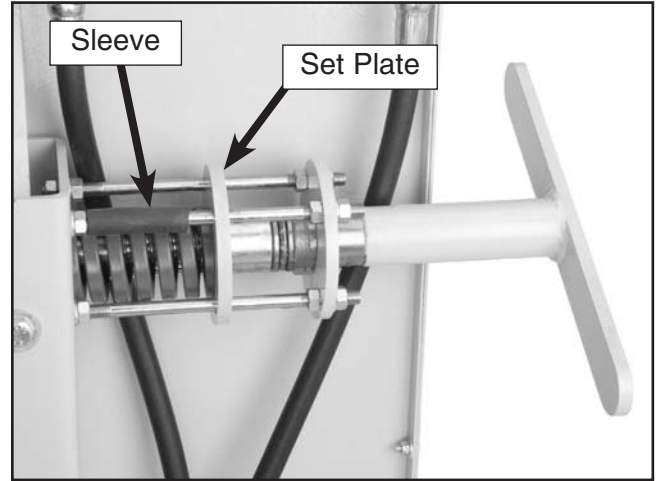
**Figure 20.** Blade positioned between guides.

- Position the blade on the wheels so the tooth gullet is approximately  $\frac{1}{16}$ " over the edge of the wheel as illustrated in **Figure 21**.



**Figure 21.** Illustration of proper blade position.

- Hand tighten the handle until the set plate comes in contact with the sleeve shown in **Figure 22**.



**Figure 22.** Blade tensioning handle.

- Turn the wheels clockwise by hand.
  - If the blade remains centered, does not touch any guides, and the support bearing is approximately 0.016" behind the back of the blade, continue on to *Connecting to the Power Source*.
  - If the bottom of the blade gullets do not remain centered on the wheels, then turn to *Tracking* on **page 40** for adjustment instructions.
  - If the blade rubs on the blade guides, turn to *Adjusting the Blade Guides* on **page 42** for adjustment instructions.
  - If the support bearing turns when the blade is rotated, go to *Adjusting the Support Wheel* on **page 43** for adjustment instructions.



# Connecting to Power

Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking power disconnect lever near the machine. See **page 12** for wiring recommendations.

If you have performed all of the previous set up instructions, you are ready to connect the resaw to the power source.

| Tools Needed                    | Qty |
|---------------------------------|-----|
| Phillips Head Screwdriver ..... | 1   |

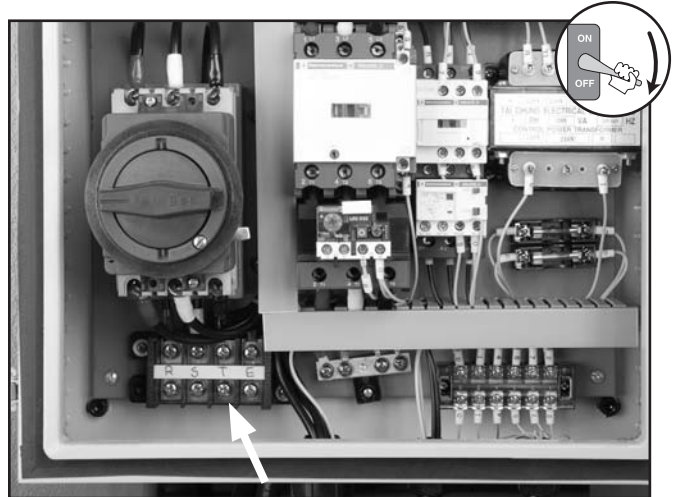
| Hardware Needed                  | Qty    |
|----------------------------------|--------|
| Conduit (Not Included) .....     | Varies |
| Power Wires (Not Included) ..... | Varies |

## To connect the resaw to the power source:

1. Read through *Section 2: Circuit Requirements* on **page 12** to double-check that your setup follows the safety and circuit requirements.

*Note—When using a phase converter, the power from the manufactured power leg (sometimes called the wild wire) can fluxuate. Connect the manufactured power leg to the S terminal to prevent damage to the transformer. The wire from the S terminal can handle some fluxuation because it goes directly to the motor. The power going to the R and T terminals goes to the transformer and must be consistent to prevent damage.*

2. Connect the power wires to the main terminal shown in **Figure 23**.



**Figure 23.** Main terminal.

3. Close and latch the electrical panel on the machine.
4. **Shut off the main power at the power source circuit breaker.**
5. Connect the conduit to the shut off lever box and the bottom of the electrical panel.
6. Install the power wires to the disconnect switch.



# Test Run

## WARNING

Before starting the resaw, perform the preceding assembly and adjustment instructions, and read and understand the entire manual. Failure to follow this warning could result in serious personal injury or death!

### To test run the resaw:

1. Make sure the wheel cover is closed and all tools or other objects are cleared away from the resaw.
2. Put on safety glasses and hearing protection, and make sure any bystanders are wearing safety glasses and hearing protection and are out of the way.
3. Turn the EMG STOP switch (shown in **Figure 24**) clockwise until it pops up.



**Figure 24.** Power switches.

4. Turn the POWER ON switch (shown in **Figure 24**) clockwise.
5. Press the MOTOR START button and immediately press the EMG STOP button. As you are standing in front of the machine, make sure that the blade is moving from left to right.
  - If the blade is moving the wrong direction, swap the incoming power supply wires at the **R** and **T** locations on the main terminal block inside the electrical cabinet— this will reverse the blade direction.
  - If the blade is moving in the correct direction go to **step 5**.
5. Turn the EMG STOP switch clockwise until it pops up. Press the MOTOR START button again.
  - If any problems occur, immediately press the EMG STOP button. Turn to *Troubleshooting* on **page 68** and correct the problem before operating the machine further.
  - If you cannot easily locate the source of an unusual noise or vibration by yourself, please contact our service department at (570) 546-9663.
6. Press the PUMP START button. Push the conveyor lever forward to test the conveyor belt. If the conveyor belt does not turn after pushing the conveyor lever forward, rotate the conveyor speed knob counterclockwise.
  - If any problems occur, immediately press the EMG STOP button. Turn to *Troubleshooting* on **page 68** and correct the problem before operating the machine further.
  - If you cannot easily locate the source of an unusual noise or vibration by yourself, please contact our service department at (570) 546-9663.



# Blade Tension

The only way to accurately tension the blade on this machine is with a blade tensioner such as the Model H5408 on **page 33**. This method is for rough blade tensioning only.

| Tools Needed             | Qty |
|--------------------------|-----|
| Hex Wrench 4mm .....     | 1   |
| Wrench/Socket 17mm ..... | 2   |

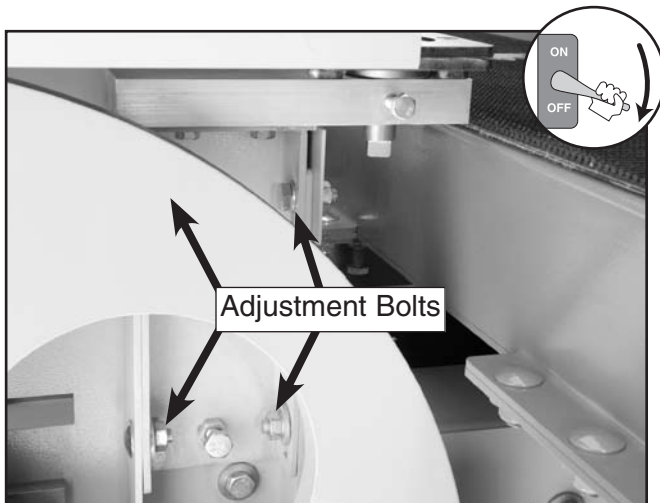
## To adjust the tension:

1. **Disconnect the resaw from power!**
2. Remove the upper plate shown in **Figure 25**.



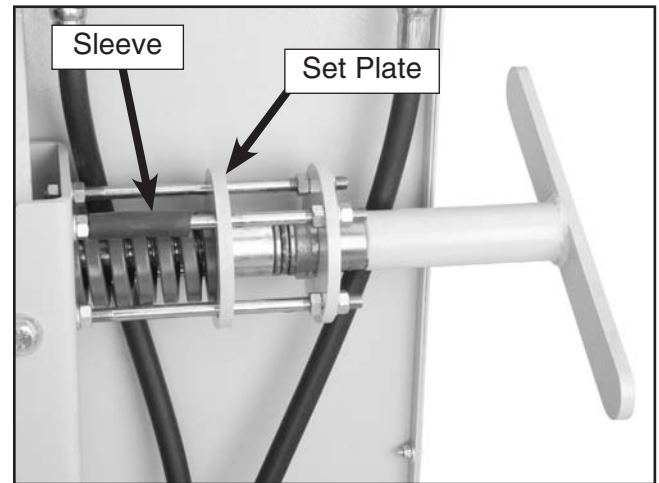
**Figure 25.** Blade guide upper plate.

3. Loosen the vertical adjustment bolts shown in **Figure 26** and lower the guide block.



**Figure 26.** Vertical adjustment bolts. One adjustment bolt is not visible.

4. Hand tighten the handle until the set plate contacts the sleeve shown in **Figure 27**.



**Figure 27.** Blade tensioning handle.

5. Turn the bandsaw **ON**.
  - If the blade flutters, increase the tension until the fluttering stops, then increase the tension an additional quarter turn.
  - If the blade does not flutter, decrease the tension until it begins to flutter, then re-tension until it stops fluttering, then increase the tension an additional quarter turn.
6. Turn the resaw **OFF** and disconnect the resaw from the power source!
7. Replace the blade guide upper plate and set the guides as explained in *Adjusting the Blade Guides* on **page 42**.

If the blade does not cut properly, the tension may be incorrect. Re-adjust the tension. A tension that worked well on a new blade may not work on an old blade because blades stretch with use. Bandsaw blades will last longer and stretch less if they are de-tensioned after each use.

## **NOTICE**

**These instruction are for rough tensioning only. The only way to accurately tension the blade is with a blade tensioner. Premature blade breakage is often caused by improper blade tensioning.**

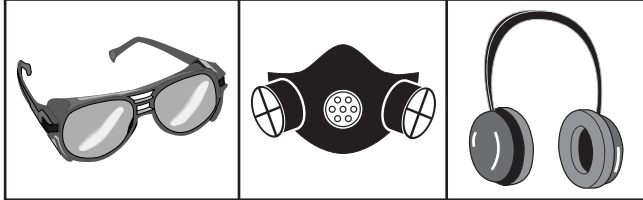


# SECTION 4: OPERATIONS

## Operation Safety

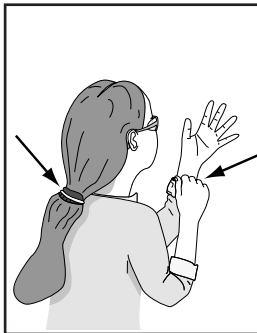
### **WARNING**

Eyes, lung, and ear damage could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



### **WARNING**

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.



### **NOTICE**

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, trade magazines, or get formal training before using this machine. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training or knowledge.



## Stock Preparation

Always make sure that any stock you plan on cutting is clean and free of nails, staples, or embedded stones.

Keep in mind that precision cuts require a more extended preparation process than rough cuts.

**To prepare the workpiece for a precision cut:**

1. **Surface plane the workpiece on a jointer**—The concave face of the workpiece should be planed flat on a jointer.
2. **Surface plane the workpiece on a thickness planer**—The opposite face of the workpiece should be planed flat with a thickness planer.
3. **Edge joint the workpiece on a jointer**—The concave edge (viewed from end-to-end) of the workpiece should be edge jointed flat on a jointer. This flat edge will glide along the fence rollers during the resaw operation.





# Blade Height

The blade height is the distance between the conveyor table and the bottom of the blade.

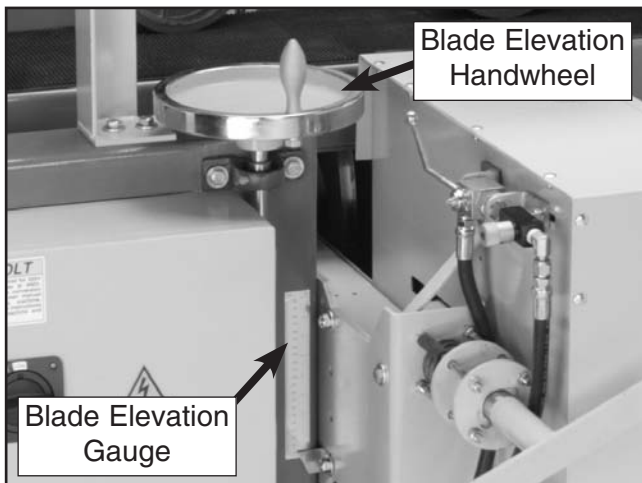
## NOTICE

The resaw blade may come into contact with the conveyor belt if lowered below 1/4".

### To set the blade height:

1. **Disconnect the resaw from the power source!**
2. Turn the blade elevation handwheel (shown in **Figure 28**) counterclockwise to raise the blade or clockwise to lower the blade. Use the elevation gauge to determine the height.

Note: Six rotations of the handwheel raises the blade approximately 1/4".



**Figure 28.** Blade elevation handwheel.

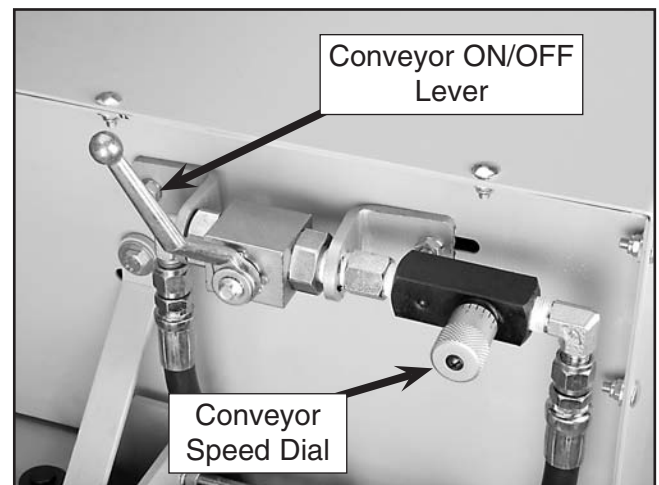
3. Connect the resaw to power and cut a test piece.
4. Measure the test piece to ensure the thickness matches the elevation gauge reading. —If the wood thickness is different than indicated on the elevation gauge, turn to *Blade Elevation Gauge* on **page 43** for adjustment instructions.

# Conveyor Controls

The Model G0503 features a variable speed infeed conveyor to move lumber through the blade. Slow the conveyor speed to get a smooth cut on hard wood, and speed it up for softer woods.

### To operate the infeed conveyor:

1. Push the PUMP START button on the control panel.
2. Push the conveyor ON/OFF lever (**Figure 29**) forward (toward the conveyor belt) to start the conveyor.



**Figure 29.** Conveyor controls.

3. Turn the conveyor speed dial (**Figure 29**) counter-clockwise to increase the speed or clockwise to decrease the speed.
4. Pull the engagement lever back (away from the conveyor) to stop conveyor.



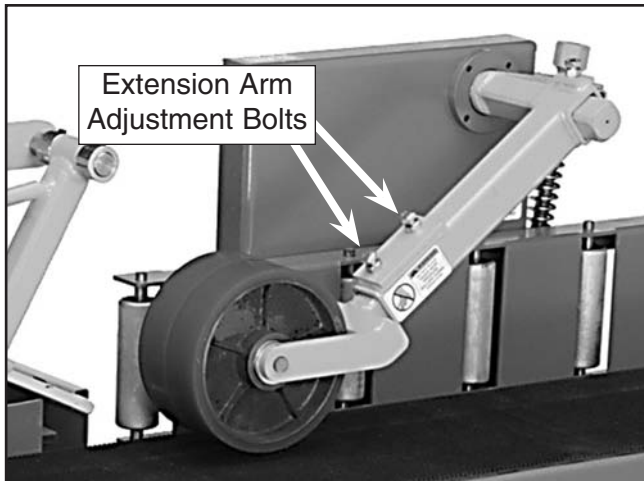
# Pressure Rollers

The pressure rollers hold the workpiece against the conveyor table for a smooth cut.

| Tools Needed             | Qty |
|--------------------------|-----|
| Hex Wrench 5mm .....     | 1   |
| Wrench/Socket 17mm ..... | 2   |
| Wrench 35mm .....        | 1   |

## To adjust the pressure rollers:

1. **Disconnect the resaw from power!**
2. Loosen the jam nuts and hex bolts that secure the extension arm of the infeed pressure roller (see **Figure 30**).



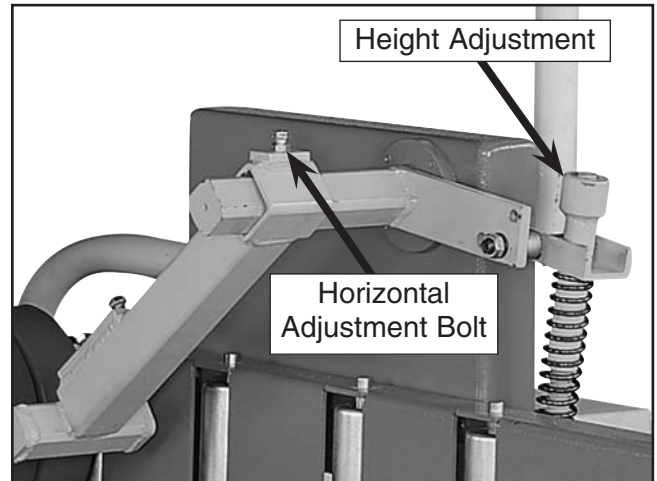
**Figure 30.** Infeed pressure roller.

3. Extend the pressure roller close to the blade and tighten the jam nuts and hex bolts. Make sure the extension arm can rotate without hitting the pressure roller on the blade.

## **NOTICE**

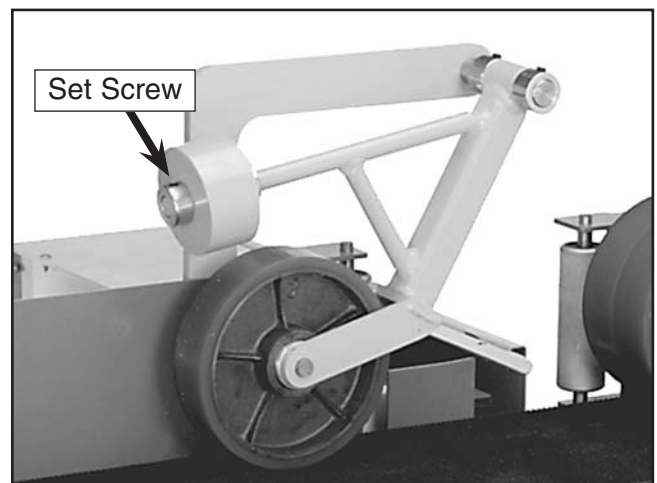
**The blade can move into the infeed pressure roller when the blade height is changed. Prevent damage by checking the pressure rollers each time the blade is adjusted.**

4. Loosen the horizontal adjustment bolt indicated in **Figure 31**, center the pressure rollers on the workpiece, then retighten the bolt and jam nut.



**Figure 31.** Pressure roller adjustments.

5. Rotate the height adjustment nut to raise or lower the infeed pressure roller.
  - Adjust the pressure roller to apply pressure to the top of the workpiece, but not touch the table after the workpiece passes.
  - When working with thick workpieces, adjust the pressure roller so the workpiece does not hit the extension arm before contacting the pressure rollers.
6. If the workpiece hangs up on the outfeed pressure roller, loosen the set screws shown in **Figure 32**, and slide the weight up the shaft, then tighten the set screws.



**Figure 32.** Outfeed pressure roller.



# Resawing

## ⚠ CAUTION

DO NOT cut slices thinner than 1/4" off of the bottom of the stock. Attempting to cut thin slices off of the bottom may cause the blade to cut into the conveyor belt.

### To perform a resawing operation:

1. Make sure the blade is installed and tensioned correctly as described in *Installing the Blade* on page 22.
2. Set the blade to the desired height.  
—To cut off of the top of the stock; place the stock on the conveyor and align the top of the blade level with the top of the stock. Remove the stock from the conveyor and lower the blade the desired amount.  
—To cut off of the bottom of the stock; rotate the handwheel until the blade elevation gauge reads the desired height. Note—Six rotations of the handwheel raises the blade approximately 1/4".
3. Turn the POWER ON switch clockwise to supply power and press the MOTOR START button to start the bandsaw blade.
4. Push the PUMP START button and move the conveyor ON/OFF lever forward to start the conveyor belt (see Figure 33).

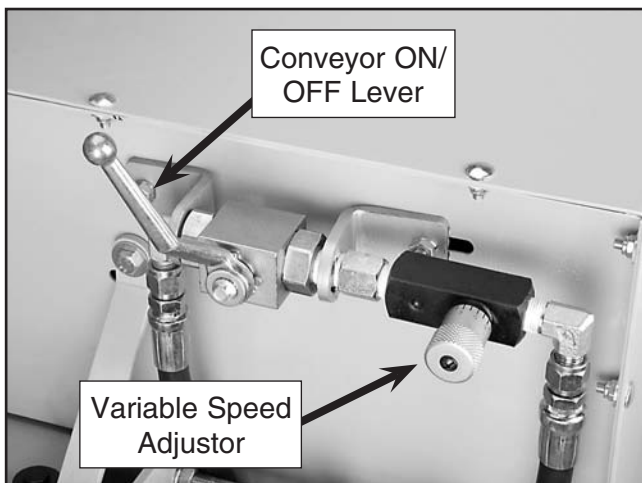


Figure 33. Conveyor controls.

5. Adjust the conveyor speed with the variable speed adjustor shown in Figure 33. If the blade continually rotates the support bearing, reduce the speed of the conveyor.

## NOTICE

Running the conveyor too fast can push the blade into the support bearing, grooving the bearing and causing blade breakage.

6. Make sure the workpiece is clean and free of nails, staples, or embedded stones, and has two sides that are relatively flat and parallel with each other.
7. Begin feeding the workpiece under the front pressure rollers with a flat edge against the guide rollers, as shown in Figure 34.

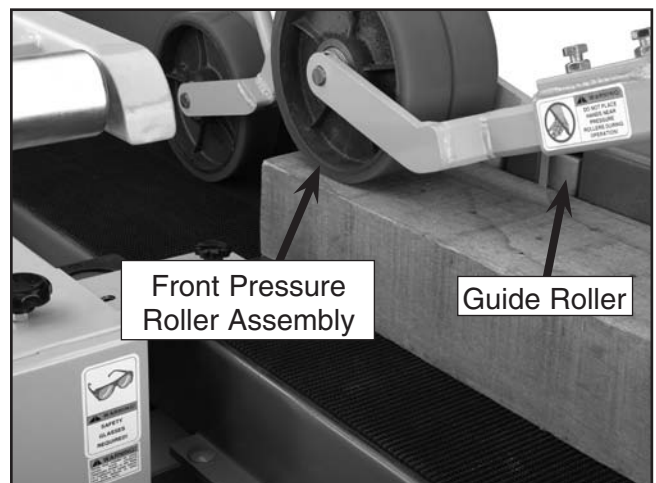


Figure 34. Feeding the workpiece through the bandsaw.

8. Receive the workpiece on the outfeed side of the machine. Note—If a second person is receiving the workpieces, use the return rollers to send them back to the person on the infeed side.

## NOTICE

Always de-tension blade after use. Bandsaw blades will last longer and stretch less if de-tensioned after each use.





# Blade Information

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The Model G0503 is a specialized machine that requires specialized blades. Grizzly Industrial has selected a series of blades for optimum performance on this machine. The only variables when selecting a blade are the type of cutting tooth and the number of teeth-per-inch (Tooth Pitch).

## Blade Tooth Type

**Carbon Steel**—The less expensive carbon steel blades are adequate for most cutting applications; however, they dull quickly and for economical reasons they are usually replaced rather than resharpened.

**Carbide Tipped**—The more expensive carbide-tipped blades are designed for continuous use in production shop situations. They hold an edge longer than carbon steel and they can be resharpened many times before needing to be replaced.

## Tooth Pitch

Tooth pitch refers to the number of teeth-per-inch. The more teeth-per-inch, the smoother the resulting cut, but the feed rate must be relatively slow. The less teeth-per-inch, the rougher the resulting cut, but the feed rate can be set faster. Some trial and error may be necessary to find the right combination of cut quality, tooth pitch and feed rate.

## Blade Length

The required blade length for the Model G0503 is 168".

## Blade Width

The required blade width for the Model G0503 is 1".

## Blade Care

The resaw blade is a precision ground piece of steel, subject to tremendous strain. Increase the life and performance of your blade by using the correct feed rate and tension.

A clean blade will perform much better than a dirty blade. A dirty blade passes through the cutting material with much more resistance than a clean blade. This extra resistance will also cause unnecessary heat. Maintain your blades with a cleaner like OxiSolv® and a cutting blade lubricant like Boeshield® T-9 shown on **page 32**.

A cool blade will last longer than a blade that is overheated. The best way to keep the blade cool is with a coolant dispenser like the Grizzly model H4959 shown on **page 33**.

## Blade Breakage

Blade breakage is unavoidable in some cases, since it is the natural result of the peculiar stresses placed on the blade. Blade breakage may also be due to avoidable circumstances, which is most often the result of poor care or judgment on the part of the operator when mounting the blade, tensioning, or adjusting the support guides.

**The most common causes of blade breakage are:**

- Incorrect blade tension.
- Feeding the workpiece too fast.
- Dull teeth or insufficient set.
- Not releasing blade tension after use.
- Faulty adjustment of the blade guides.
- Using a blade with an improperly finished braze or weld.
- Running the bandsaw excessively when not resawing.



# SECTION 5: ACCESSORIES

## H3788—G96® Gun Treatment 12 oz. Spray

## H3789—G96® Gun Treatment 4.5 oz. Spray

This triple action gun treatment cleans, lubricates and protects all metal parts. Contains solvents that completely remove all traces of rust and corrosion and leaves no gummy residue.



Figure 35. G96® Gun Treatment spray.

## G1955—OxiSolv® Blade & Bit Cleaner

Used to clean the gummy pitch and residue from saw blades and router bits, this high quality cleaner will make blades and bits last longer while improving cutting action.



Figure 36. G1955 OxiSolv® spray.

## G2871—Boeshield® T-9 12 oz Spray

## G2870—Boeshield® T-9 4 oz Spray

This ozone friendly protective spray penetrates deep and really holds up against corrosive environments. Lubricates metals for months and is safe for use on most paints, plastics, and vinyls.



Figure 37. Boeshield® T-9 spray.

## G7895—Citrus Degreaser

This citrus based degreaser is perfect for cleaning cosmoline off of new equipment. It also works for cleaning auto parts, tools, concrete, and porcelain surfaces. Natural, safe for the environment, and contains no CFC's.



Figure 38. G7895 Citrus Degreaser.

Call 1-800-523-4777 To Order

Model G0503 (Mfg. Since 12/08)

### Lenox® Blades

Replacement blades for the Model G0503 Horizontal Resaw Bandsaw.

| MODEL | TYPE        | WIDTH | GAUGE  | TPI |
|-------|-------------|-------|--------|-----|
| H4874 | Carbon      | 1"    | 0.035" | 1.3 |
| H4875 | Carbide Tip | 1"    | 0.035" | 2-3 |
| H4876 | Carbide Tip | 1"    | 0.035" | 3-4 |

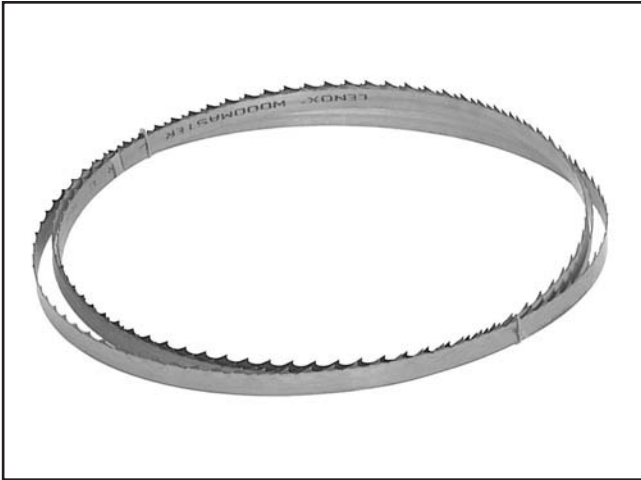


Figure 39. Lenox® bandsaw blade.

### H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.

The Blade Tensioning Gauge is made of lightweight, cast aluminum for optimum accuracy. Bright color coding makes it easy to use and easy to read. The Blade Tensioning Gauge comes in a handy metal box with instructions on the lid.



Figure 40. H5408 Blade Tensioning Gauge.

Model G0503 (Mfg. Since 12/08)

### H4959—Coolant Dispenser

Delivers a small amount of lubricant to the cutting surface to improve tool life and cutting efficiency. An absolute must for large resawing operations.



Figure 41. H4959 Coolant Dispenser.

### H6895—Band-Ade for Wood, 8 oz

### H6896—Band-Ade for Wood, 1 Gal

### H6897—Band-Ade for Wood, 5 Gal

This cutting fluid is designed to lubricate and retard resin and pitch buildup on the following applications: guided gang saws, edgers, band mills, trim saws, planers, molders, finger jointers, re-saws and bandsaws. Excellent for use in the Model H4959 Coolant Dispenser.



Figure 42. H6897 Band-Ade for Wood, 5 Gal.

Call 1-800-523-4777 To Order

**P0503A17—440V Conversion Kit**

This kit allows the Model G0503 to run on 440V power. 440V power offers better start capacity, cooler motor operation, and increased motor life.



**Figure 43.** 440V overload relay.

- H2499—Small Half-Mask Respirator**
- H3631—Medium Half-Mask Respirator**
- H3632—Large Half-Mask Respirator**
- H3635—Cartridge Filter Pair P100**

Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around-dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



**Figure 51.** Half-mask respirator with disposable cartridge filters.

- T20501—Face Shield Crown Protector 4"**
- T20502—Face Shield Crown Protector 7"**
- T20503—Face Shield Window**
- T20452—"Kirova" Anti-Reflective S. Glasses**
- T20451—"Kirova" Clear Safety Glasses**
- H0736—Shop Fox® Safety Glasses**
- H7194—Bifocal Safety Glasses 1.5**
- H7195—Bifocal Safety Glasses 2.0**
- H7196—Bifocal Safety Glasses 2.5**



**Figure 78.** Eye protection assortment.

- H4978—Deluxe Earmuffs - 27dB**
  - H4979—Twin Cup Hearing Protector - 29dB**
  - T20446—Ear Plugs 200 Pair - 31dB**
- Protect your hearing before its too late. Especially important if you or employees operate for hours at a time.

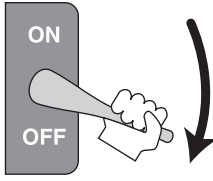


**Figure 42.** Hearing protection assortment.

**Call 1-800-523-4777 To Order**



# SECTION 6: MAINTENANCE

|   |   |
|---|---|
|  | <p><b>⚠ WARNING</b><br/>Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.</p> |
|---|---|

## Cleaning

### Inside Wheel Cover

To keep the bandsaw working properly, regularly open the wheel cover and vacuum any sawdust from the machine that did not make it into the dust collector.

### Resaw Wheels and Scrapers

Use a dry rag to wipe sawdust from the wheel scrapers. Remove sawdust build up on the wheels by rotating the wheels by hand while holding the dry rag on the contact surface.

### Conveyor Belt

Use compressed air to clean the built-up sawdust from the conveyor belt. *Eye injuries frequently occur when cleaning with compressed air—wear safety glasses to protect yourself! Also wear a dust mask or respirator to protect your lungs from airborne dust particles.*

### Painted Surfaces

These areas may be cleaned with a dry or damp rag; however, make sure you DO NOT clean bare metal surfaces with a damp rag or they may rust.



## Miscellaneous

Always be aware of the condition of your machine. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts
- Worn switch
- Worn or damaged blade
- Worn or damaged support bearings



## V-Belts

To ensure optimum power transmission from the motor to the blade and to the hydraulic pump, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension. Check the V-belts at least every three months; more often if the bandsaw is used daily.

See *Adjusting V-Belt Tension* on **page 48** for instructions on properly tensioning the belts or for replacing the belts, if needed.



## Bearings

Except for the bearings that are fitted with grease fittings, the bearings are sealed and pre-lubricated and require no lubrication during their usable life. All bearings are standard sizes, and replacements can be purchased from our parts department or a bearing supply store.





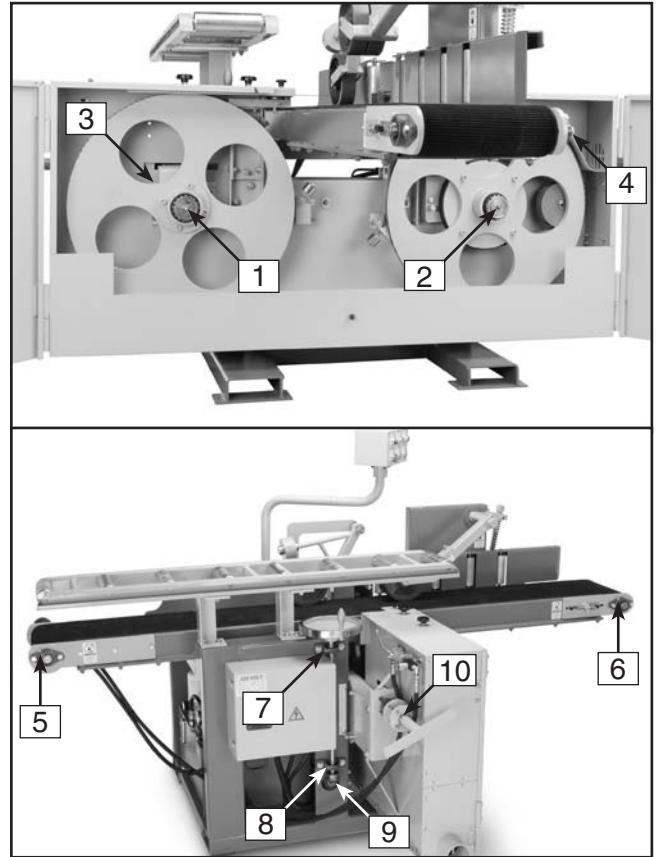
# Greasing

**Tools Needed** Qty  
Grease Gun..... 1

**Hardware Needed** Qty  
High Temp Bearing Grease .....Varies  
Multi-Purpose Grease .....Varies

Wipe grease fittings clean and lubricate with two pumps of high-temp bearing grease. To lubricate a greased surface; wipe the surface clean and apply a thin coating of multi-purpose grease.

The photos in **Figure 47** label the grease fittings and greased surfaces by number for easy identification. Match the numbers in **Figure 47** to the chart below for proper greasing intervals. Note—*This page was designed to be copied and used as a check-off chart to help maintain a regular lubrication schedule.*



**Figure 47.** Lubrication points.



Check white boxes after lubricating fittings. Date Started:

Note — 160 hours is the equivalent of 1 month of regular use.

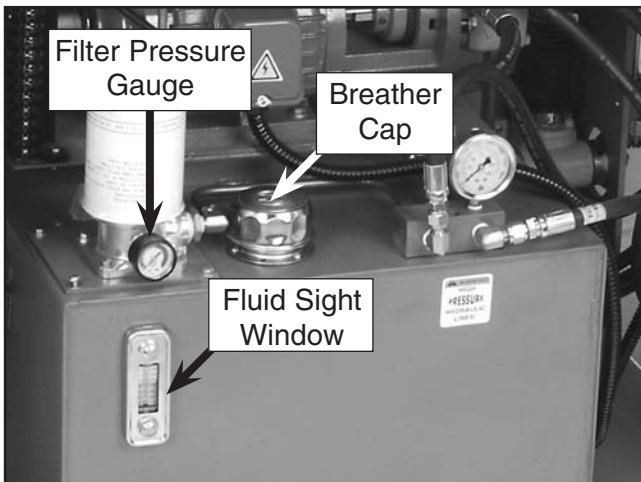
| <b>G0503 GREASE SCHEDULE/CHECK-OFF CHART</b> |   |              |     |     |     |     |     |
|--|---|--------------|-----|-----|-----|-----|-----|
| MACHINE AREA                                 | FITTINGS<br>(See Fig. 47 for fitting locations) | HOURS OF USE |     |     |     |     |     |
|  |   | 160          | 320 | 480 | 640 | 800 | 960 |
| Main Wheels                                  | 1,2   |              |     |     |     |     |     |
| Blade Tension Slide                          | 3,  |              |     |     |     |     |     |
| Conveyor                                     | 4,5,6   |              |     |     |     |     |     |
| Elevation Shaft                              | 7,8   |              |     |     |     |     |     |
| Elevation Gear                               | 9   |              |     |     |     |     |     |
| Tension Handle                               | 10  |              |     |     |     |     |     |

# Hydraulic Fluid Schedule

In order for the hydraulic system to operate the conveyor properly and at the correct temperature, the hydraulic fluid level in the tank should be  $\frac{2}{3}$  full between the fill lines on the fluid sight window, which is located on the front of the tank (see **Figure 48**).

## Check the hydraulic fluid level daily.

To add hydraulic fluid, wipe the dust and dirt from the breather cap shown in **Figure 48** and remove the cap. Fill the tank to the full line with an ISO VG 46 hydraulic fluid. If this machine is used in extreme cold conditions use ISO VG 32 hydraulic fluid; use ISO VG 68 hydraulic fluid for extreme hot environments.



**Figure 48.** Hydraulic reservoir components.

## Inspect and clean the breather cap and filler screen every 40 hours of regular use.

Visually inspect both the breather cap and the plastic screen that sits in the tank opening. If there is visual contamination, clean both items with solvent and compressed air. Allow them to completely dry before installing back in the tank. **DO NOT** pour hydraulic fluid from the center of the screen back into the tank.



# Hydraulic System Minor Service

The hydraulic system minor service consists of changing the filter, cleaning the breather cap and filler screen, and inspecting the hydraulic fluid for signs of thermal breakdown, dust contamination, and water contamination.

**Perform a “Minor Service” every 960 hours, or when the filter pressure gauge (see **Figure 48**) nears the red.**

## **!WARNING**

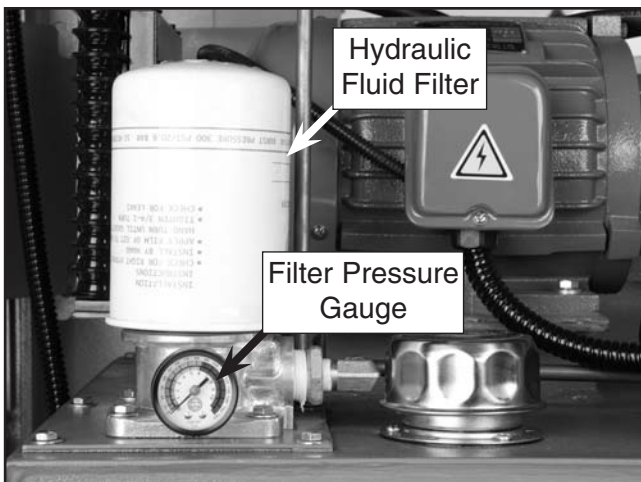
**The hydraulic system on this machine creates very high pressure and the hydraulic fluid gets hot. Always stop the resaw, make sure the pressure gauge reads 0 PSI, and make sure the fluid cools down before servicing the hydraulic system.**

## To inspect the hydraulic fluid:

1. Look at the color of the hydraulic fluid in the sight window.
  - If the fluid is milky in appearance, then the hydraulic fluid is contaminated with water.
  - If the fluid is dark brown or opaque, then the hydraulic fluid is severely contaminated or thermal breakdown has occurred.
2. Smell the hydraulic fluid (remove breather cap).
  - If the fluid smells rancid or burnt, then the hydraulic fluid has overheated and thermal breakdown has most likely occurred. Correct the component that is causing thermal breakdown (See *Troubleshooting* on **page 68**).
3. Determine what service is needed.
  - If the fluid is transparent and does not smell burnt or rancid, perform a minor service.
  - If the fluid is opaque, smells rancid or burnt, fix the source of contamination or the component causing thermal breakdown, then perform a major service.

**To change the filter:**

1. **Read and understand the hydraulic safety instructions on page 11 before continuing!**
2. **Disconnect the resaw from the power source!**
3. Thoroughly clean the area around the filter to prevent contamination of the hydraulic fluid.
4. Remove the filter shown in **Figure 49**. Replacement filter kits can be ordered from Grizzly Industrial using part number P0503B74.



**Figure 49.** Hydraulic fluid filter.

5. Dry the filter base to remove any excess hydraulic fluid.
6. Rub clean grease on the filter gasket and screw the new filter into the filter base.
7. Tighten the filter by hand until the gasket contacts the base—then tighten another full turn.
8. Plug in the resaw and start the conveyor belt.
9. Inspect the hydraulic system for leaks.



# Hydraulic System Major Service

A major service consists of performing a “Minor Service,” plus draining the fluid, cleaning the tank and screen, and filling the tank with new fluid.

## **!WARNING**

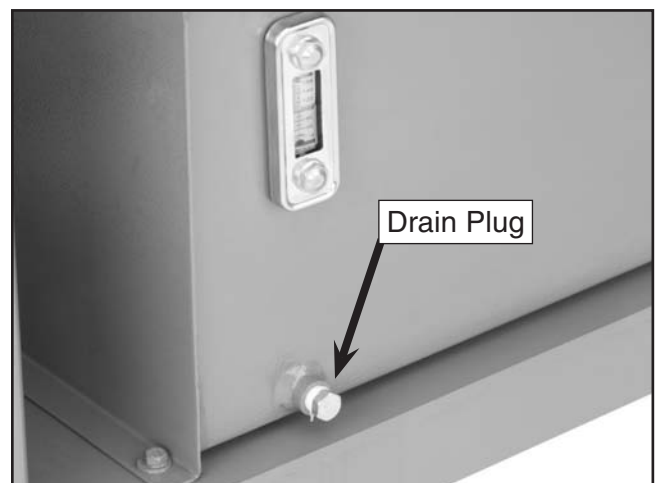
**The hydraulic fluid is hot and under high pressure when the hydraulic pump motor is running. Always stop the resaw, make sure the pressure gauge reads 0 PSI, and make sure the fluid is cool before servicing.**

| <b>Tools Needed</b>      | <b>Qty</b> |
|--------------------------|------------|
| Wrench/Socket 17mm ..... | 1          |
| Wrench/Socket 10mm ..... | 1          |
| Drain Pan 20 Gal.....    | 1          |

| <b>Supplies Needed</b>         | <b>Qty</b> |
|--------------------------------|------------|
| ISO VG 46 Hydraulic Fluid..... | 14 Gal     |
| Solvent .....                  | Varies     |

**To drain the hydraulic fluid:**

1. **Disconnect the resaw from the power source!**
2. With your drain pan in place, remove the drain plug shown in **Figure 50** and allow the tank to completely drain.



**Figure 50.** Hydraulic tank drain plug.



## To clean the tank screen:

1. Thoroughly clean the area around the tank access plate to prevent contamination of the hydraulic fluid.
2. Remove the access plate bolts shown in **Figure 51**.



**Figure 51.** Tank access plate.

3. Carefully lift the access plate, pivoting around the hinge fitting in the tubing.
4. Inspect the access plate gasket for leakage. Replace with part P0503B76-1 if worn.
5. Remove the tank screen from inside the tank, clean it with solvent and compressed air, and allow it to dry.
6. Use a lint free rag to wipe up and remove any sludge from the bottom of the tank.
7. Use clean hydraulic fluid on a clean rag to wipe up additional contaminants from the bottom and sides of the tank.
8. Re-install the tank screen, replace the access plate and gasket on top of the tank, and install the drain plug.
9. Fill the tank with ISO VG 46 hydraulic fluid until the sight window is  $\frac{2}{3}$  full between the hi and low marks on the sight window. Note—*This will take approximately 14 gallons.*

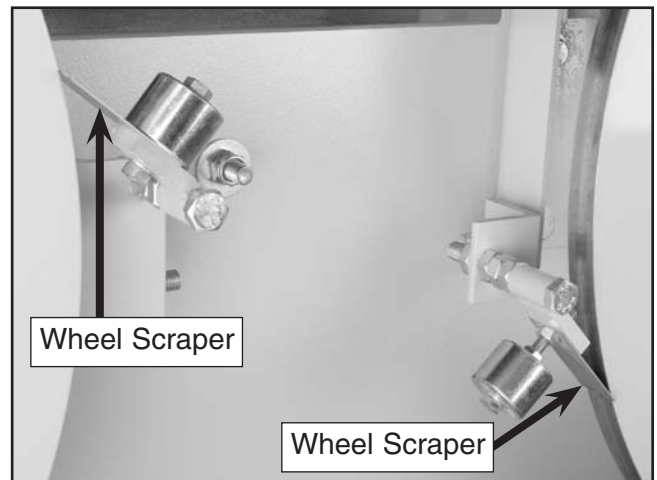
# Wheel Scrapers

The wheel scrapers ride directly on the wheels removing dust and shavings. The constant motion of the wheels cause the scrapers to wear down. Eventually they will need to be replaced.

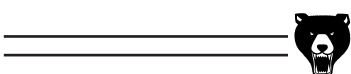
| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 13mm ..... | 1   |

## To replace the scrapers:

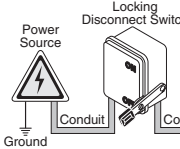
1. **Disconnect the resaw from the power source!**
2. Inspect the scraper to determine if it needs replaced. If the scraper is nearly parallel with the wheel, it should be replaced.
3. Remove the nut and lock washer.
4. Unthread the weight from the pivoting plate and remove the scraper.
5. Replace the scraper with part P0503522.
6. Replace the weight, lock washer, and nut.
7. Position the scrapers so the tip is against the rotation of the wheel as shown in **Figure 52**.



**Figure 52.** Wheel scrapers.



# SECTION 7: SERVICE



**WARNING**  
Always disconnect power to the machine before performing service adjustments. Failure to do this may result in serious personal injury.

## About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.



## Tracking

Blade tracking consists of aligning the wheels to keep the blade centered when the wheel is rotated under full tension. When replacing blades fine tuning may be necessary, but this entire process should not have to be repeated unless the wheels are removed.

| Tools Needed          | Qty |
|-----------------------|-----|
| Straightedge .....    | 1   |
| T-Handle Wrench ..... | 1   |
| Wrench 19mm .....     | 1   |
| Hex Wrench 4mm.....   | 1   |

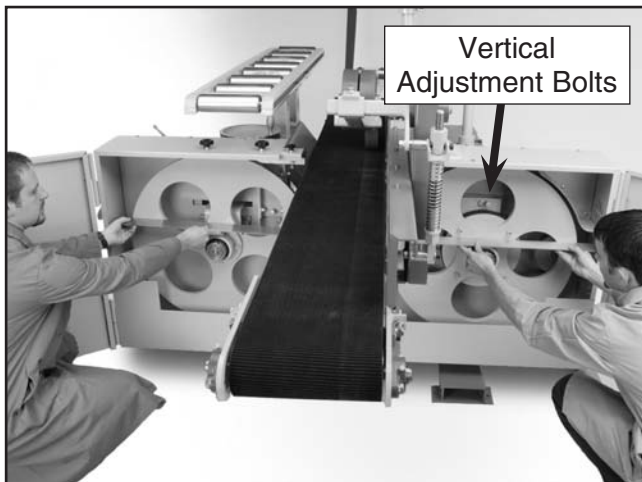
### To track the blade:

1. **Disconnect the resaw from the power source!**
2. Move the blade guides out of the way.
3. Turn the wheels by hand. If the bottom of the blade gullets do not remain approximately  $\frac{1}{16}$ " away from the front edge of the wheels, then adjust the tracking.
4. Place two flat bars under the conveyer belt and place a square against the fixed wheel as shown in **Figure 53**. Make note of the angle between the wheel and the square.



**Figure 53.** Vertical wheel adjustment.

5. Move the bars to the other side of the conveyor belt and check the adjustable wheel.
  - If the wheels have the same angle compared to the conveyor table, go to **step 8**.
  - If the wheels have different angles, proceed to **step 6**.
6. Loosen the lock bolts and the jam nuts on the vertical adjusting bolts at the top of the adjusting plate shown in **Figure 54**.



**Figure 54.** Straightedge placement.

7. **Tilting Forward**—To move the top of the wheel forward, loosen the lock bolt and tighten the neighboring adjustment bolt. Always loosen the jam nuts before moving the adjustment bolts, and always tighten the jam nuts after moving the adjustment bolts.

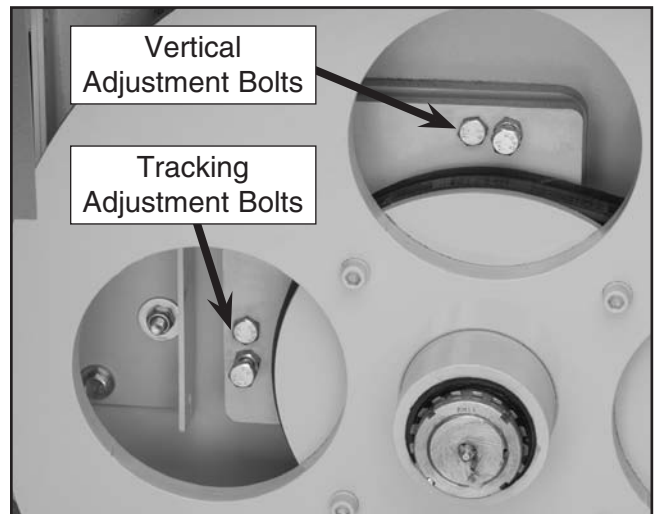
**Tilting Backward**—To move the top of the wheel backward, loosen the adjustment bolt, then tighten the neighboring lock bolt.

8. Place the straightedge across the wheels, as shown in **Figure 54**, and examine how the wheels line up with each other.
  - If the straightedge lies flat across the surface of both wheels as shown in **Figure 55**, skip to **step 11**.
  - If the wheels are not aligned, determine which direction they need to move in order to be correct, then proceed to **step 9**.



**Figure 55.** Correct alignment.

9. Loosen the jam nuts on the tracking adjusting bolts and loosen the lock bolts. (See **Figure 56**)



**Figure 56.** Tracking adjustment bolts.

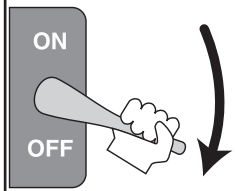
10. Adjust the wheels until the wheel position is correct when checked with the straightedge.
11. Spin the wheels by hand to check tracking.
12. Fine tune the adjustment bolts until the blade tracks correctly.
13. Adjust the guide bearings, close the wheel cover, and connect the machine to the power source to prepare the saw for a test run.
14. Test run the resaw and repeat this entire section if the blade does not track correctly.



# Adjusting the Blade Guides

Each blade guide assembly consists of a guide block and a support wheel.

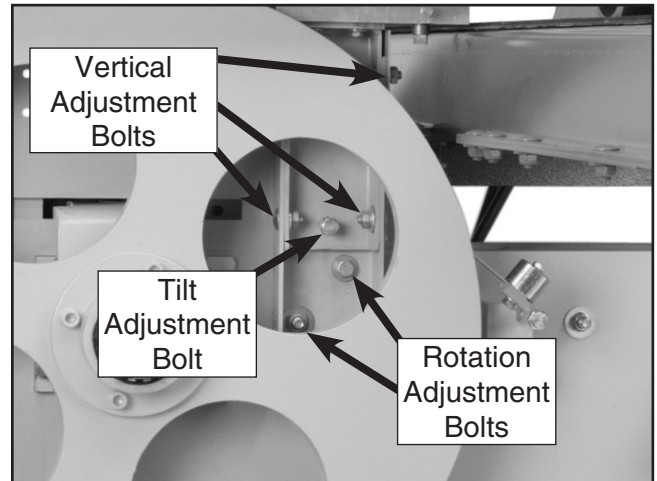
Each metal guide block has a guide slot that stabilizes the up/down movement of the blade and a support wheel to control backward movement. The guide block alignment should be checked each time a blade is installed.

|   |   |
|---|---|
|  | <p><b>! WARNING</b></p> <p>These instructions present a serious injury hazard if done while the machine is connected to power. <b>DO NOT connect to power until instructed!</b></p> |
|---|---|

| Tools Needed               | Qty |
|----------------------------|-----|
| Wrench/Socket 17mm .....   | 2   |
| T-Handle Wrench 19mm ..... | 1   |
| Wrench/Socket 19mm .....   | 1   |

## To align the guide blocks:

1. Rotate the wheels by hand and watch how the blade feeds through the blade guides.
  - If the blade feeds through the blade guide without touching the guide block or rotating the support wheel, no adjustment is necessary.
  - If the blade rotates the support wheel but does not touch the guide blocks, go to *Adjusting the Support Wheel* on **page 43**.
  - If the blade rubs against the guide blocks, continue to the next step.
2. Loosen the vertical adjustment bolts shown in **Figure 57** if the blade is not centered vertically in the guide slot.



**Figure 57.** Guide block adjusting bolts. (fourth vertical adjustment bolt hidden behind the wheel in this picture).

3. Shift the blade guide adjusting bracket until the blade is centered in the guide slot.
4. Tighten the vertical adjustment bolts and repeat **step 1**.
5. Loosen the lower two vertical adjustment bolts if the blade guide is tilted so the blade touches the front or back.
6. Loosen the lock nut on the tilt adjustment bolt indicated in **Figure 57**, and adjust the tilt adjustment bolt until the guide block is level.
7. Tighten the lock nut and the vertical adjustment bolts, and repeat **step 1**.
8. Loosen the rotation adjustment bolts shown in **Figure 57** if the blade touches the guide on the right or left sides.
9. Rotate the guide block until it is level and tighten the rotation adjustment bolts.
10. Test the alignment as described in **step 1**. Continue to make adjustments until the guide block no longer touches the blade.
11. Repeat the previous steps for the other guide block.



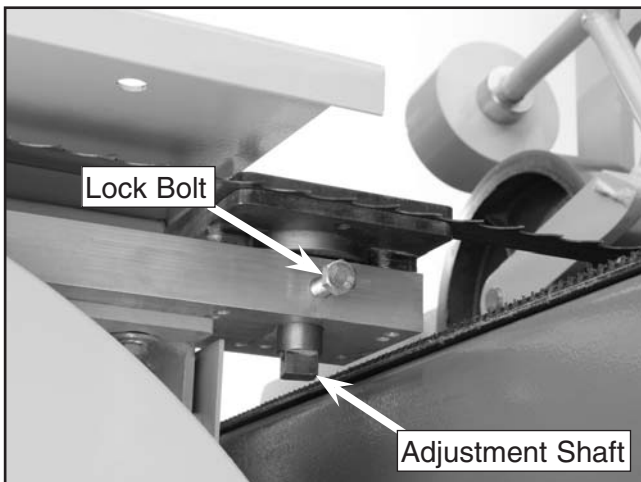
# Adjusting the Support Wheel

The support wheel is positioned behind the blade to brace it from pushing backwards during a cut. Check the support wheel spacing each time a new blade is installed.

| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 17mm ..... | 1   |

## To adjust the support wheel:

1. Loosen the lock bolt shown in **Figure 58**.



**Figure 58.** Support wheel components.

2. Rotate the adjustment shaft until the support wheel is approximately 0.016" behind the back of the blade. Check with a feeler gauge or four thicknesses of a dollar bill.
3. Tighten the lock bolt.
4. Spin the wheels clockwise by hand. If the support wheels turn, increase the spacing between the blade and the bearing (the bearings should only turn when cutting).

Note—To prevent the blade from wearing a groove into the support wheel adjust the height periodically. Move the adjustment shaft up or down until the blade contacts the support wheel in a new place.



# Blade Elevation Gauge

| Tools Needed             | Qty |
|--------------------------|-----|
| Wrench/Socket 17mm ..... | 1   |
| Calipers .....           | 1   |

## To adjust the blade elevation gauge:

1. Adjust the blade height until the blade elevation gauge reads 1/2".
2. Run a test piece through the resaw and measure the thickness of the test piece with calipers.
3. **Disconnect the resaw from power!**
4. Loosen the bolt holding the blade elevation pointer and adjust the pointer until it is set at the same thickness as the test piece.



**Figure 25.** Blade guide upper plate.

5. Tighten the blade elevation pointer bolt and run another test piece through the resaw to confirm the elevation pointer setting.





# Adjusting Main Conveyor Table

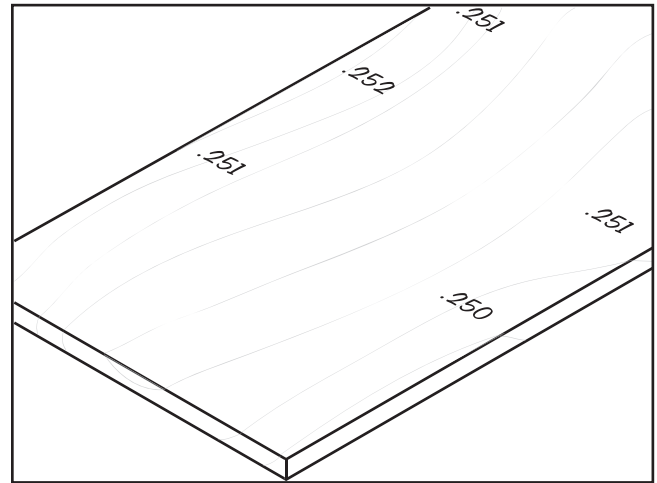
The conveyor table can be adjusted left-to-right and front-to-back to make the table parallel to the blade in both directions. This is an involved procedure that requires you to cut up a piece of test stock and make many repeat adjustments. Because of the complexity of this procedure, we will first give instructions on checking the table, so that you can be sure you need to perform the adjustment.

Before attempting these procedures, you need to have a perfectly squared piece of stock that is as wide as possible and is at least two feet long. The wider the stock, the more accurate your procedure will be (we recommend using the maximum width that the resaw will allow). Also, you need to make sure that your blade is in good condition, tracked, and tensioned properly, and the blade guides are properly adjusted.

| Tools Needed                      | Qty |
|-----------------------------------|-----|
| Caliper.....                      | 1   |
| Pencil .....                      | 1   |
| Flat Piece of Wood or Metal ..... | 2   |
| Framing Square .....              | 1   |
| Wrench 17mm.....                  | 1   |
| Hex Wrench 6mm .....              | 1   |
| Pry Tool.....                     | 1   |

## To check the main conveyor table alignment:

1. Cut a 1/4" slice off of your squared-up test stock.
2. Use a caliper to measure the thickness of the cut piece in even locations along the edges of the stock. As you take these measurements, write them directly on the stock, near the location where you took the measurement (see **Figure 59**). Note—*DO NOT measure the first and last six inches of the board, because the board will only have been under one pressure roller during that part of the cut.*

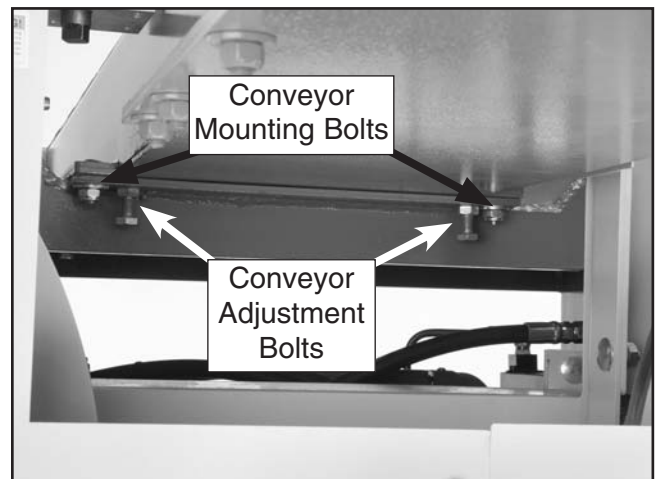


**Figure 59.** Test board with measurements.

3. Study the written test measurements.
  - If the measurements are more than 0.030" different from one side to the other, adjust the conveyor table.

## To adjust the conveyor table left to right:

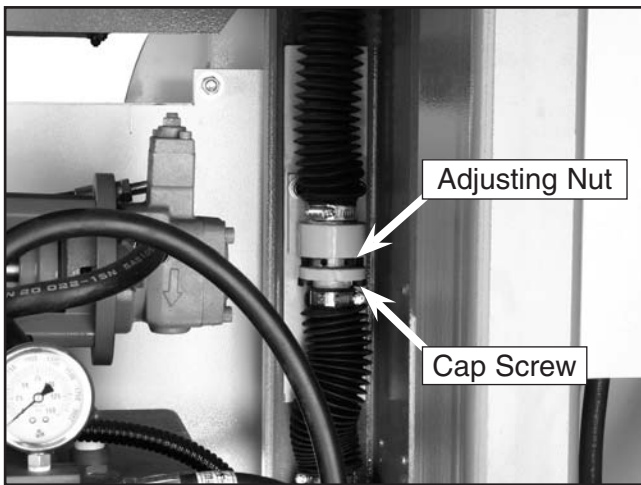
1. **Disconnect the resaw from the power source!**
2. Use your test board to determine which direction the conveyor table needs to be moved. For example, if the right side of the board was thicker than the left side—you will need to move either the right side of the conveyor up or move the left side of the conveyor down.
3. Loosen all six of the conveyor mounting bolts (see **Figure 60**).



**Figure 60.** Conveyor table mounting and adjustment bolts.



4. To raise the left side, loosen the lock nuts on the conveyor adjustment bolts on the left side and tighten the adjustment bolts. Do the same procedure to the right side bolts to raise the right side.
5. Tighten the lock nuts on the adjustment bolts and tighten the conveyor mounting bolts.
6. Connect the resaw to the power, and repeat **steps 1 and 2**.
  - If the measurements are close to correct, but need fine tuning, continue to **step 6**.
  - If large adjustments are necessary, repeat **steps 3 and 4**.
7. Loosen the cap screw shown in **Figure 61**.



**Figure 61.** Conveyor fine adjustment.

8. The adjusting nut shown in **Figure 61** raises, or lowers, the non-drive side of the bandsaw blade (the side opposite the motor). Insert the pry tool into the adjusting nut.
  - Rotate the adjusting nut to the right to raise the bandsaw blade.
  - Rotate the adjusting nut to the left to lower the bandsaw blade.
9. Retighten the cap screws, connect the resaw to the power, and repeat **steps 1 and 2**.
  - If the measurements are close to correct, but need fine tuning, continue to **step 6**.
  - If large adjustments are necessary, repeat **steps 3 and 4**.



**To adjust the conveyor table front to back:**

1. **Disconnect the resaw from the power source!**
2. Place two flat bars of wood or metal under the conveyor belt as shown in **Figure 62**.



**Figure 62.** Checking table alignment.

3. Place a square against the surface of the wheel and slide it up against the bars on the conveyor table.
  - If the square touches both bars, no adjustment is necessary.
  - If the square touches the front bar, but not the back bar, the front of the conveyor needs to be raised. Go to **step 4**.
  - If the square touches the back bar, but not the front bar, the back of the conveyor needs to be raised. Go to **step 4**.
4. Loosen all six of the conveyor mounting bolts.
5. To adjust the tilt, loosen the lock nuts on the conveyor adjustment bolts on the end that needs to be raised and tighten the adjustment bolts until the square touches both bars.
6. Tighten the lock nuts on the adjustment bolts and tighten the conveyor mounting bolts.



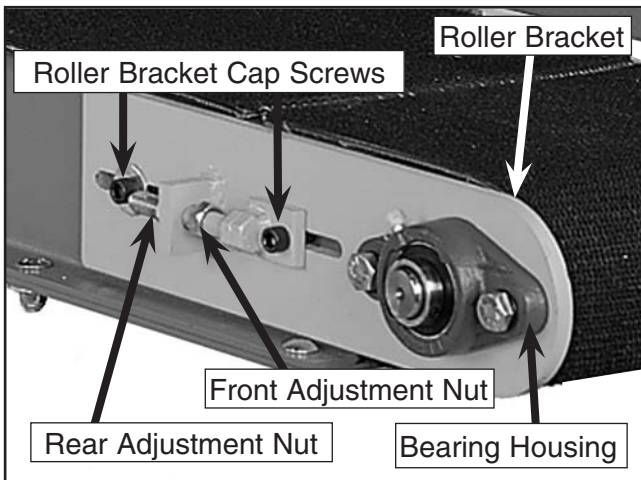
# Tracking Conveyor

The conveyor is tracking correctly when it remains centered between the roller brackets on each side of the conveyor. Adjusting the tracking is only necessary if the conveyor belt starts rubbing against the roller brackets.

| Tools Needed         | Qty |
|----------------------|-----|
| Hex Wrench 8mm ..... | 1   |
| Wrench 17mm.....     | 1   |

## To set the conveyor tracking:

1. Loosen the two roller bracket cap screws on the both sides of the conveyor (shown in **Figure 63**) about  $\frac{3}{4}$  of a turn.



**Figure 63.** Tracking adjustment components.

2. Loosen the rear adjustment nuts on both sides of the conveyor.
3. Start the conveyor belt.
4. Adjust the roller bracket that the belt is hitting by turning the front adjustment nut counter-clockwise half of a turn, and watch the belt tracking. Note—*The effect of the adjustment can sometimes take two minutes before the results are fully apparent.*  
— If the tracking was not corrected by this adjustment, proceed to **step 5**. If the tracking was corrected, skip to **step 6**.

5. On the side that the belt tracks away from, turn the front adjustment nut clockwise half of a turn, and watch the belt tracking.  
— If the tracking was not corrected by this adjustment, repeat **step 4**.
6. When the conveyor belt is tracking in the center of the roller brackets, run the conveyor for at least two minutes to ensure that it will remain tracking correctly.  
—If the tracking was not corrected by this adjustment, repeat **step 4**.  
—If the belt is tracking in the center of the infeed roller, but not centered on the outfeed roller, go to **step 7**.  
—If the belt is tracking in the center of both rollers, go to **step 9**.
7. Adjust the outfeed end of the conveyor by loosening the bolts on the outfeed bearing housing (similar to the bearing housing shown in **Figure 63**) and sliding it forward or backwards.
8. Retighten the bearing housing bolts and run the conveyor to check the tracking.  
—If the tracking was not corrected by this adjustment, repeat **step 7**.
9. Tighten the rear adjustment nuts against the bracket plates, then tighten the front adjustment nuts against the bracket plates to make sure that the tracking adjustment will not slowly change during normal operation.

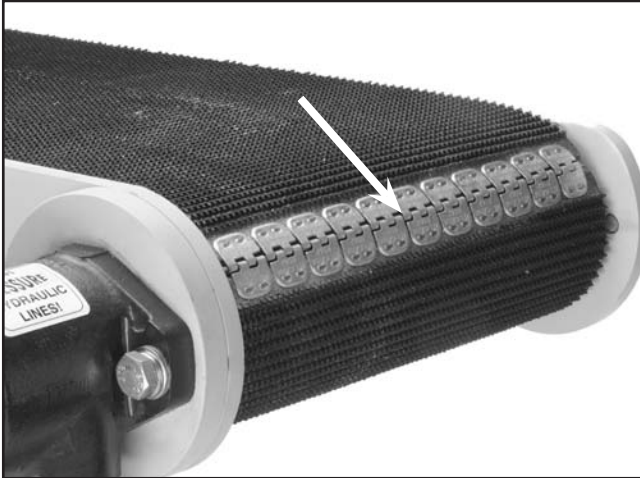


# Replacing Conveyor

---

## To replace the conveyor belts:

1. Start the conveyor belt and stop it when the conveyor belt seam (see **Figure 64**) is accessible.



**Figure 64.** Conveyor belt seam.

2. **Disconnect the resaw from the power source!**
3. Loosen the roller bracket by turning the roller bracket cap screws  $\frac{3}{4}$  of a turn (**Figure 63**).
4. Loosen the rear adjustment nuts away from the bracket plate.
5. Mark the front adjustment nut with a felt-tipped pen or a piece of tape, and thread the front adjustment nut all the way up, while keeping track of the number of full turns that you moved the nut.

*Note—Write the number of turns down, so you do not forget. Remembering this number is an important part of the re-assembly process.*

6. Slide the roller brackets toward the body of the resaw to loosen the belt.
7. Remove the stiff cable from the center of the seam to separate the conveyor belt.
8. Remove the old conveyor belt from the conveyor table, and install the new conveyor belt in its place.
9. Mesh the seam “teeth” together on the new belt, and insert the stiff cable into the center of the seam to lock it together.
10. Slide the roller brackets away from the body of the resaw to tighten the belt.
11. Thread the front adjustment bolts the same number of turns as in **step 5**.

*Note—The new belt may be tighter than the old one because it has not been broken-in. If this is the case, deduct one or two turns from your original number of turns.*

12. Run the conveyor belt to check the tracking. If the belt starts tracking to one side, stop the resaw and perform the “Tracking Conveyor” instructions that are located on **page 46**.



# V-Belt Tensioning

Adjusting the V-belts is not an exact science. Adjusting the belts too loose will decrease the performance of the machine, but adjusting the belts too tight may cause premature wear of the components attached to the belts.

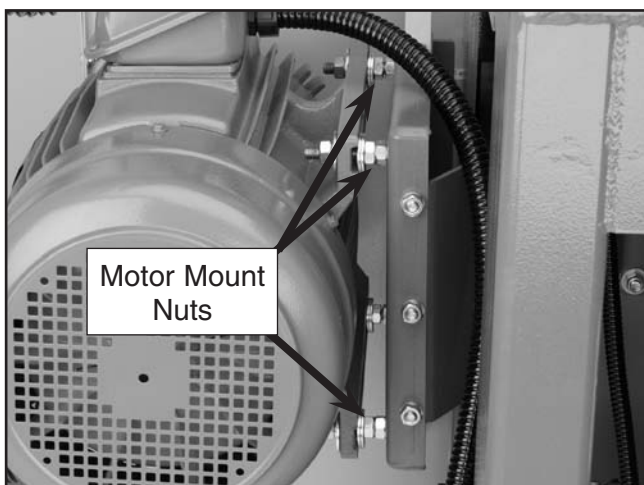
**To adjust the V-belt tension:**

1. **Disconnect the resaw from power!**
2. Press the center of each V-belt firmly. The belts should deflect between a  $\frac{1}{4}$ " and a  $\frac{1}{2}$ " (see **Figure 65**).



**Figure 65.** Checking V-belt tension.

3. Tension the V-belt by adjusting the motor mount nuts (see **Figure 66**) in or out.



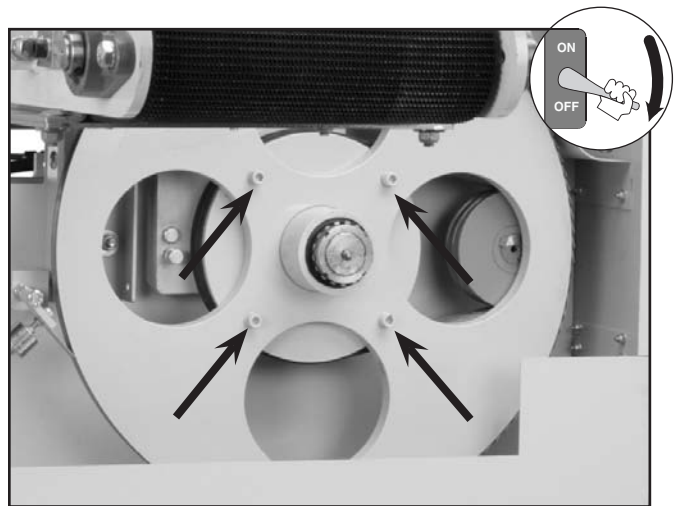
**Figure 66.** Motor mount nuts for tensioning.

# Replacing V-Belts

Replace all three V-belts at the same time to ensure uniform belt tension.

**To replace the belts that connect the motor to the wheel pulley:**

1. **Disconnect the resaw from the power source!**
2. Adjust the motor mount nuts in all the way to loosen the V-belts.
3. Place supports under the wheel and remove the cap screws shown in **Figure 67**.



**Figure 67.** Drive wheel cap screws.

|  |  |
|--|--|
|  | <p><b>CAUTION</b></p> <p>Each wheel weighs 175 lbs. Seek assistance or use power equipment to remove wheels.</p> |
|--|--|

4. Remove the drive wheel to access the wheel pulley.
5. Remove and replace all three V-belts that connect the motor to the wheel pulley.
6. Tension the new V-belts and replace the drive wheel.





# Rewiring to 440V

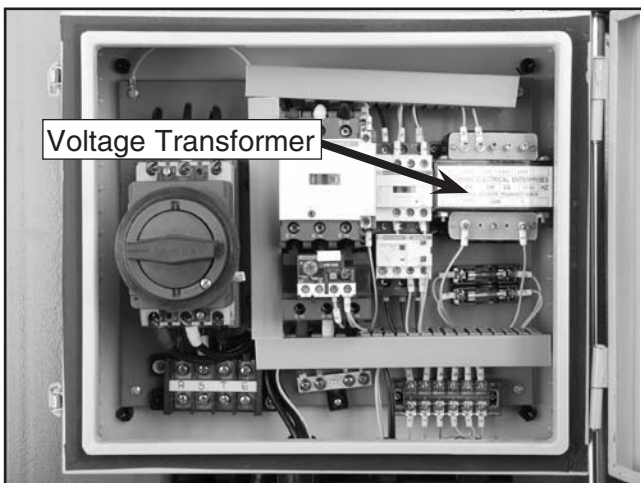
Converting the Model G0503 to 440V operation consists of 1) wiring the voltage transformer, 2) rewiring the main motor and the hydraulic pump motor, and 3) replacing the over-load relays with the relays included in the Model G0503 440V Conversion Kit (item #P0503909) that is sold separately.

## ⚠️ WARNING

Electrocution or fire may occur if your conversion does not comply with local and state codes. Have your wiring conversion inspected by a qualified electrician before connecting your machine to power.

To convert the Model G0503 to 440V:

1. Disconnect the resaw from the power source!
2. Open the electrical box and locate the voltage transformer shown in **Figure 68**.

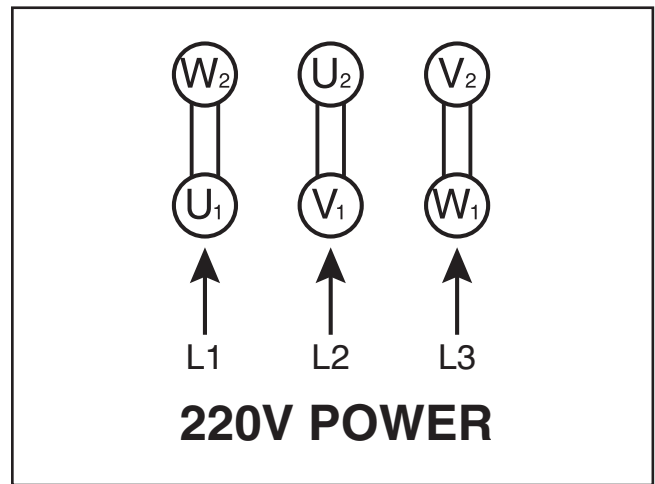


**Figure 68.** Inside of electrical box.

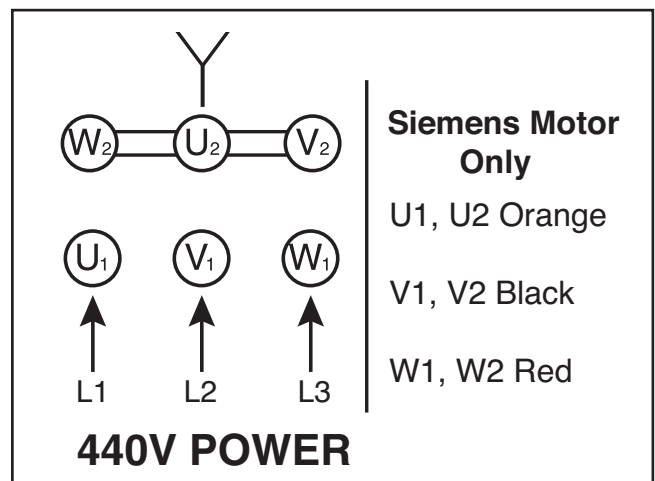
3. Move the wire from the 220V terminal on the voltage transformer to the 440V or 480V terminal depending on your voltage.
4. Replace the main motor relay with the 440V relay and set the dial to “30.”
5. Replace the hydraulic pump motor relay with the 440V relay and set the dial to “3.6.”

Model G0503 (Mfg. Since 12/08)

6. Remove the wiring covers on the main and hydraulic pump motors.
7. Wire the main and hydraulic pump drive motors as shown on the diagrams on the inside of each motor wire cover. Note—**Figures 69 & 70** are provided for reference and are current at the time that this manual was written. However, always use the diagram on the wire cover that comes with your motor! The circled references on the diagrams represent the labels on the wires.



**Figure 69.** Main motor 440V wiring.

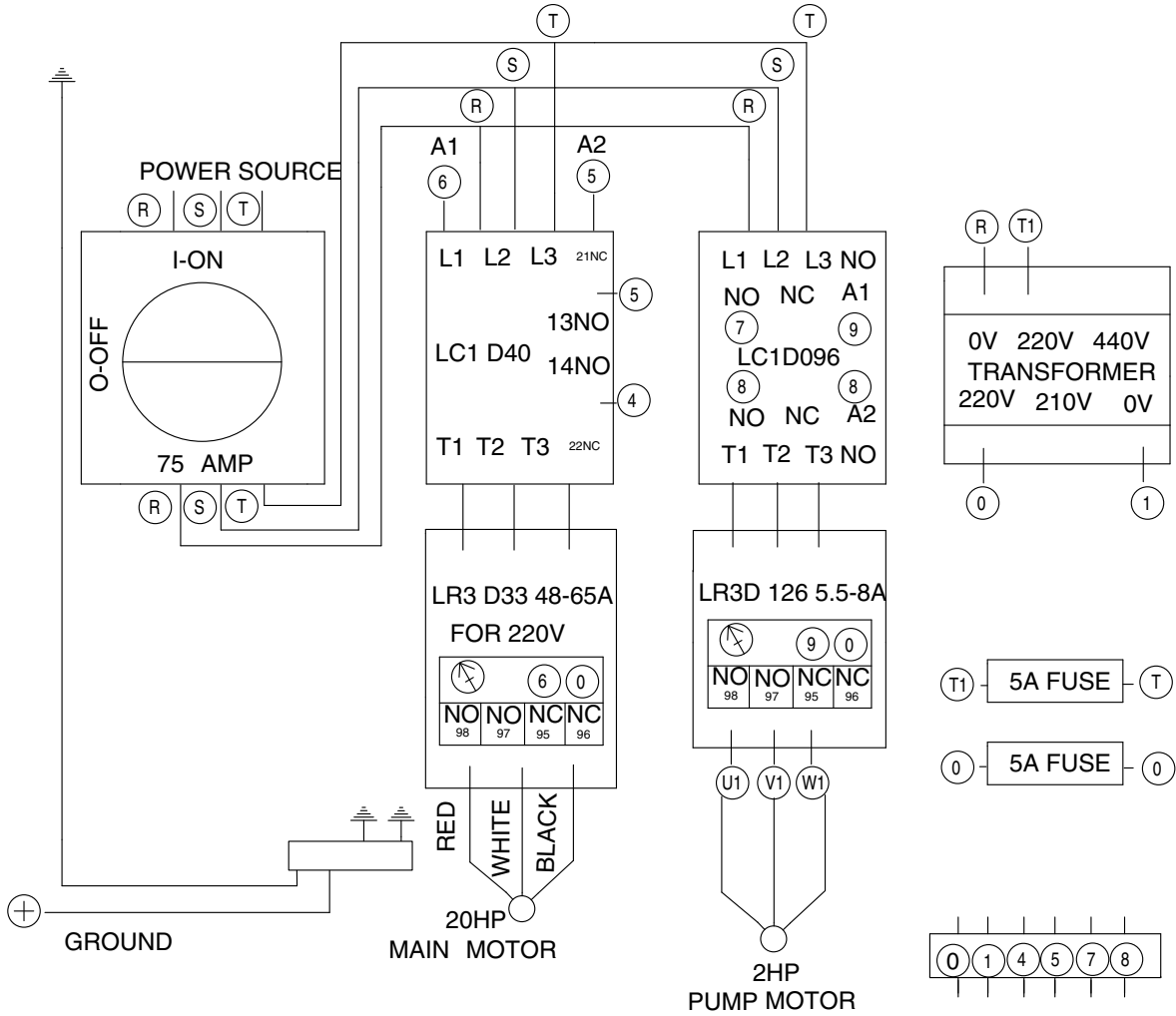


**Figure 70.** Elevation motor 440V wiring.

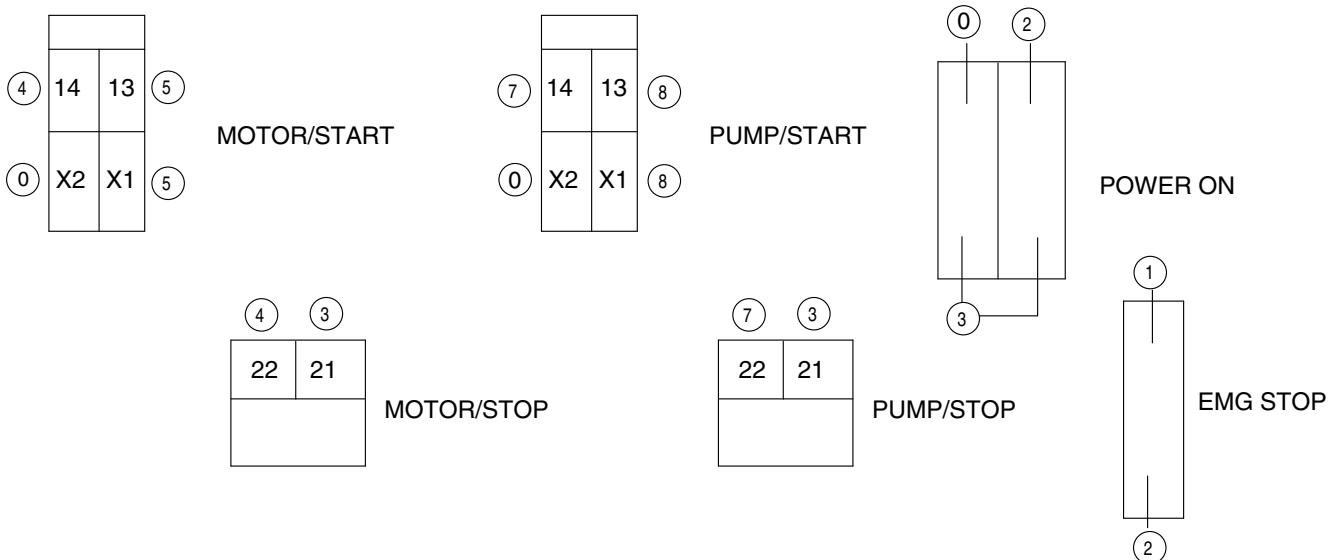
8. Replace any wire duct covers and motor caps you might have removed during this procedure, and close the electrical box door.
9. Have a qualified electrician inspect your work before test running the machine.



# G0503 WIRING

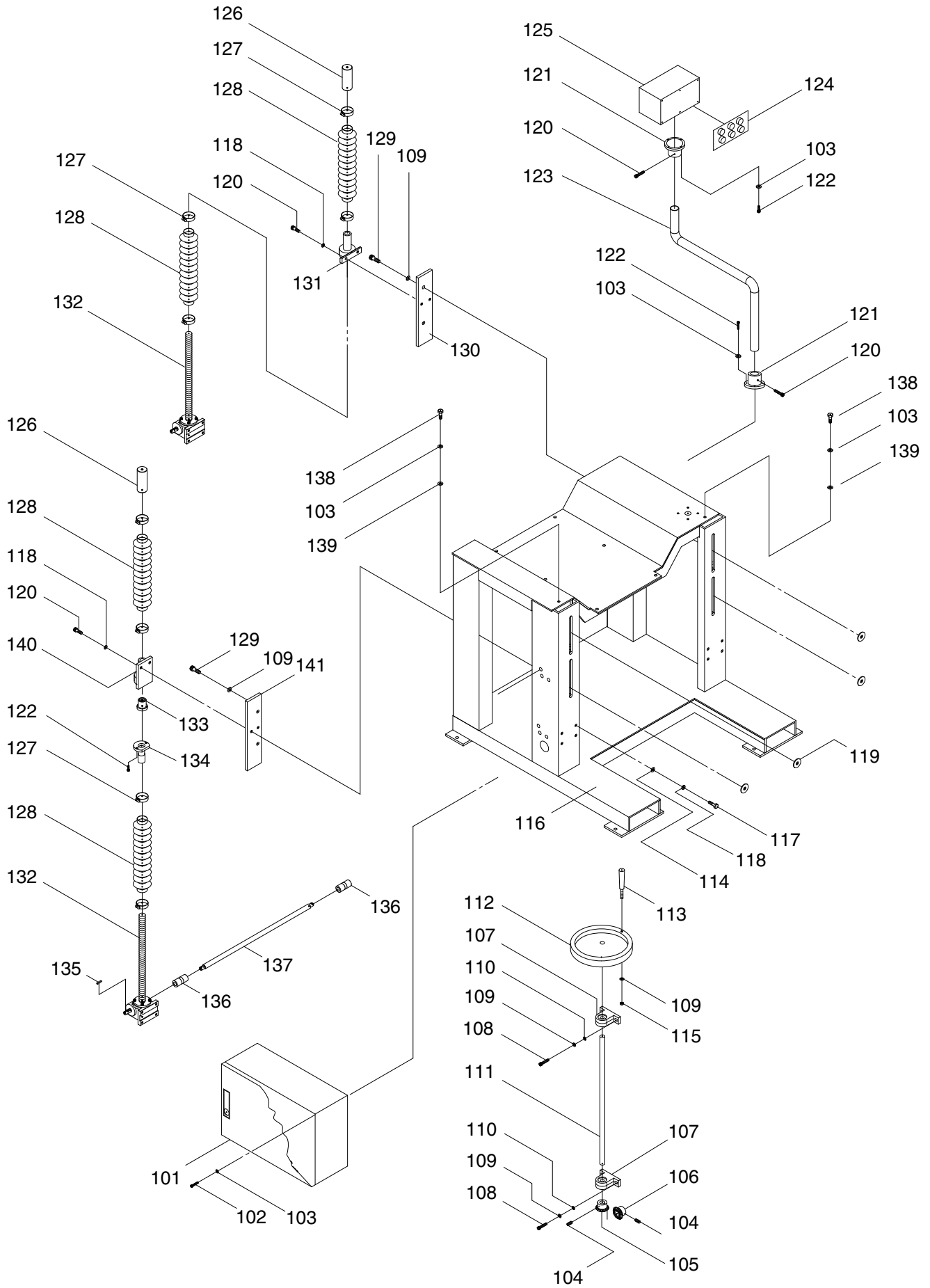


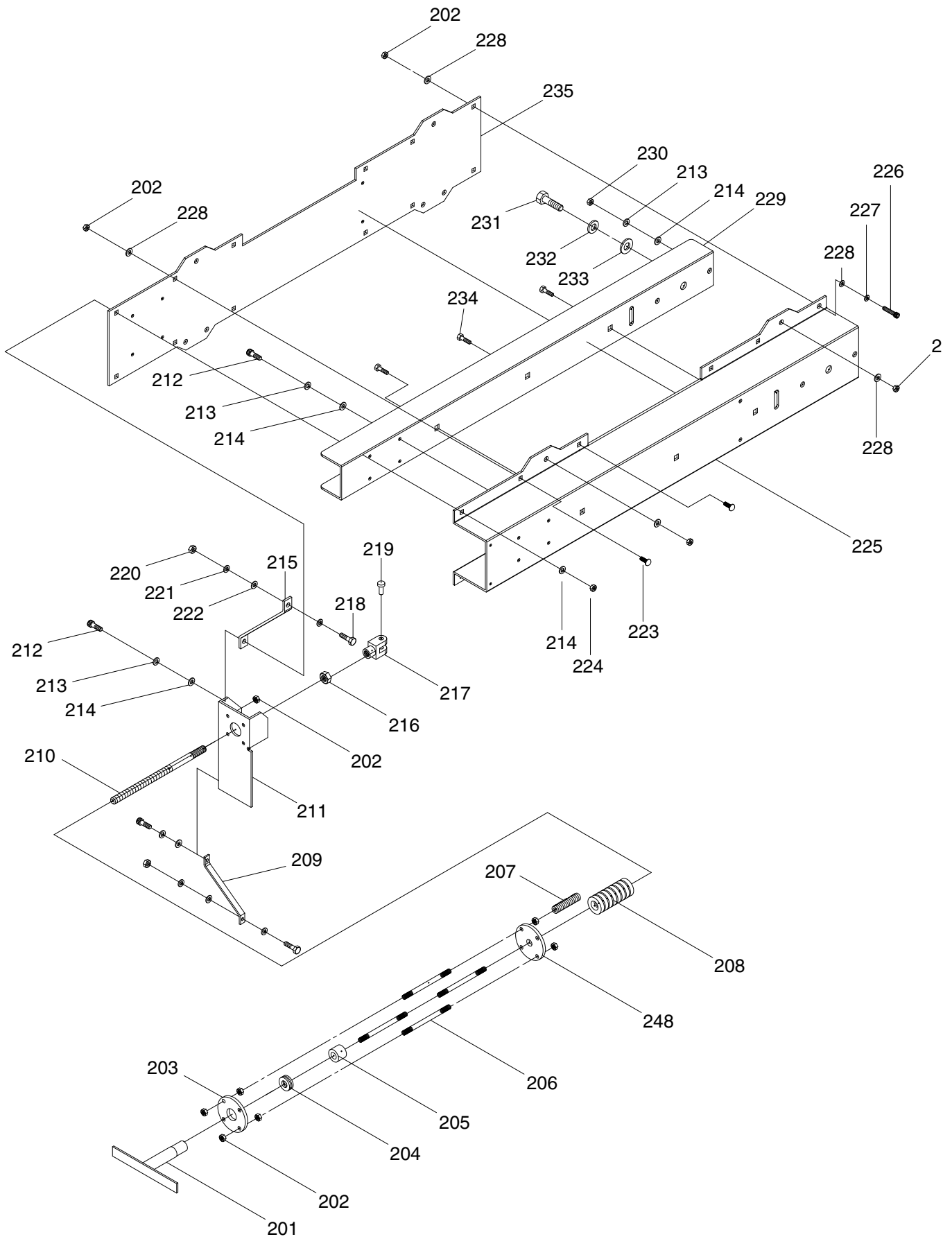
# G0503 CONTROL PANEL

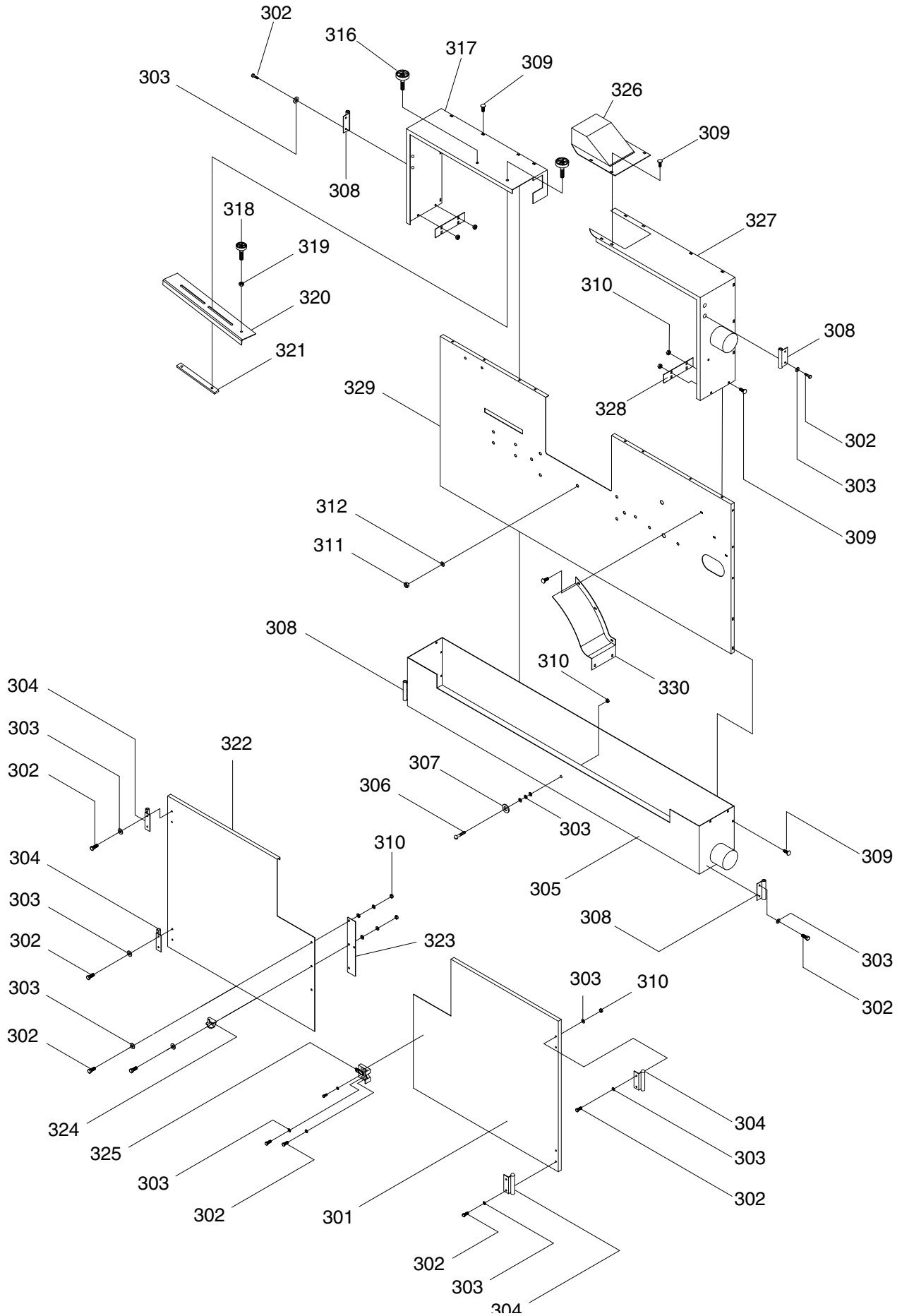


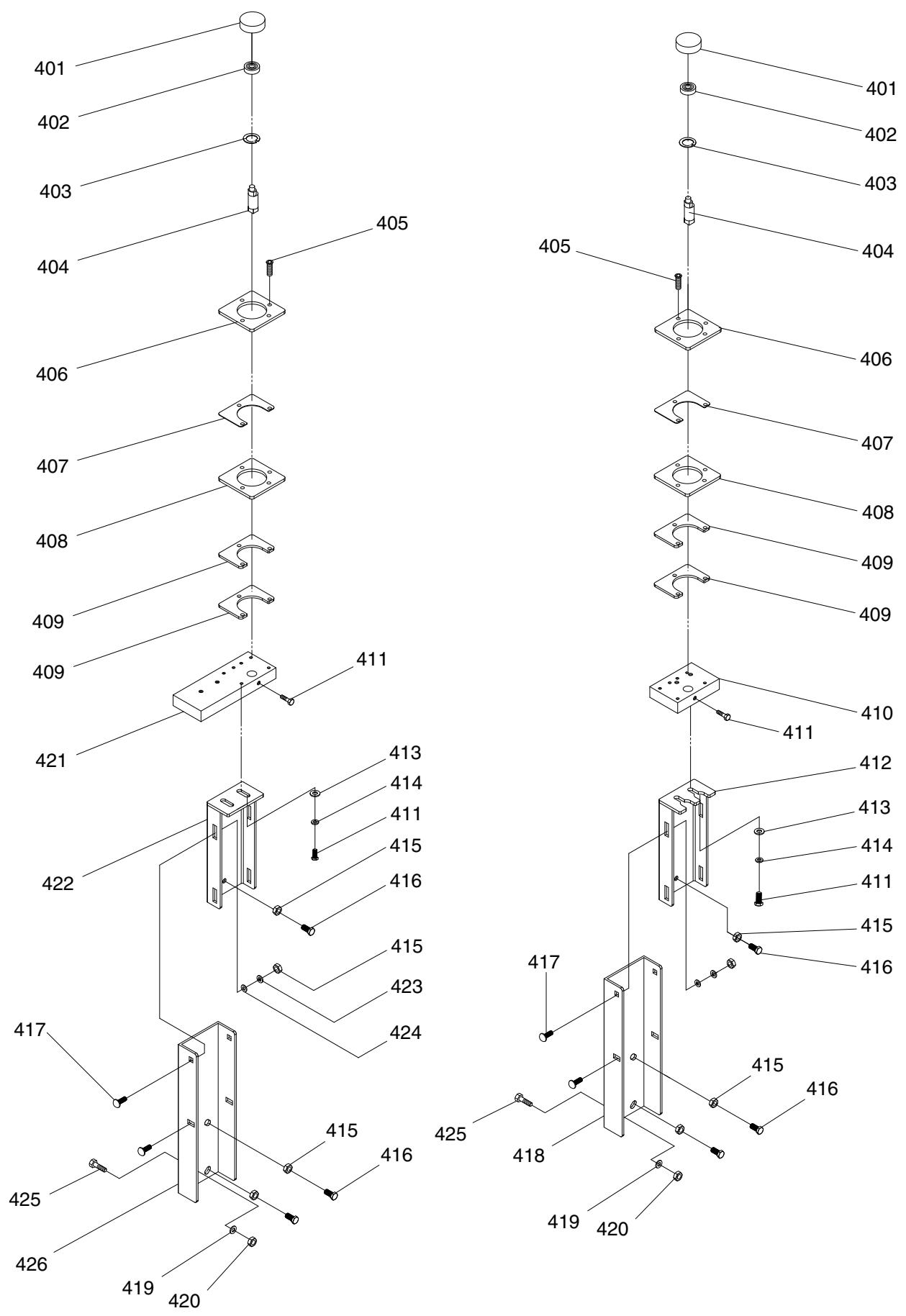


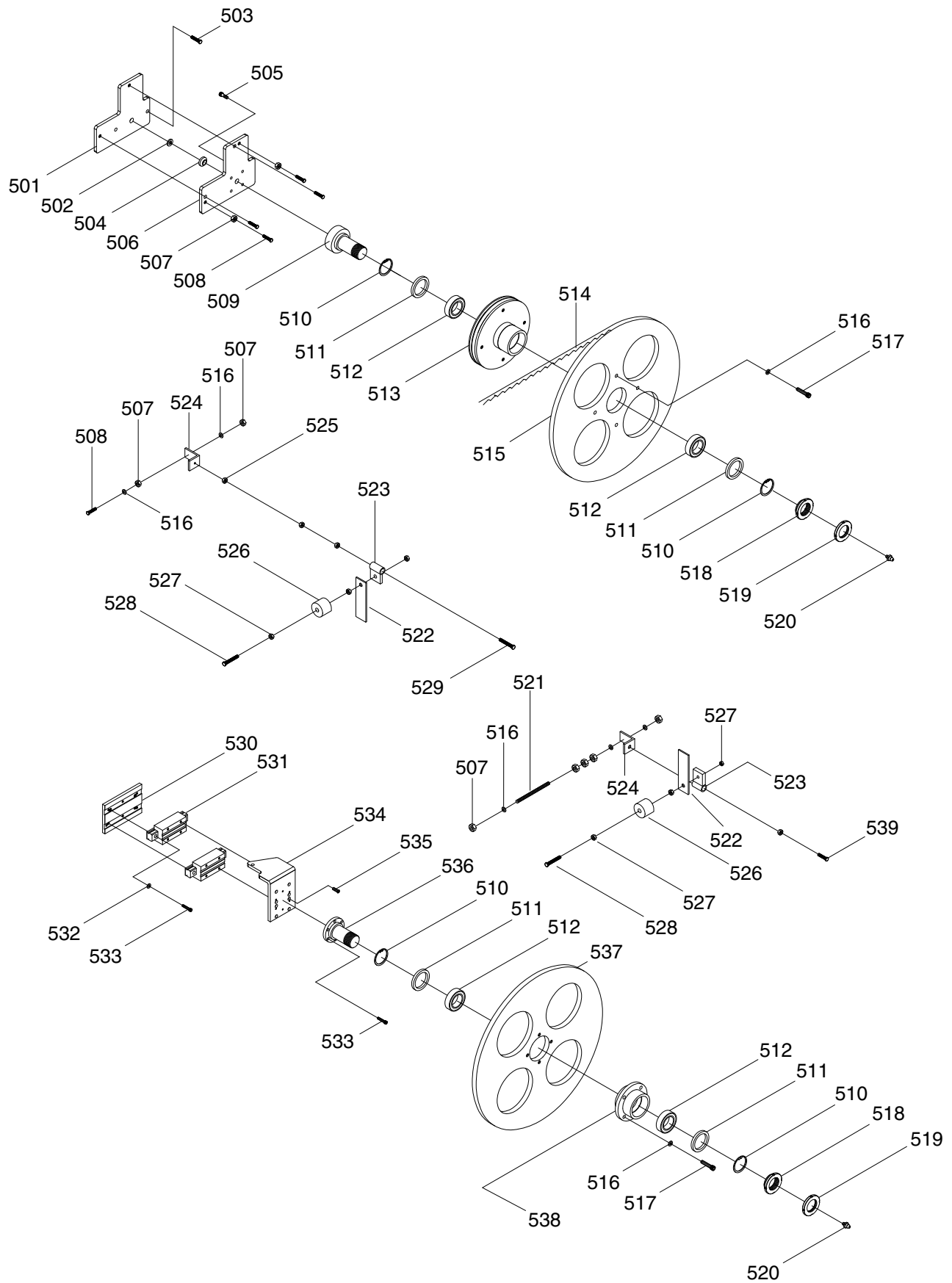






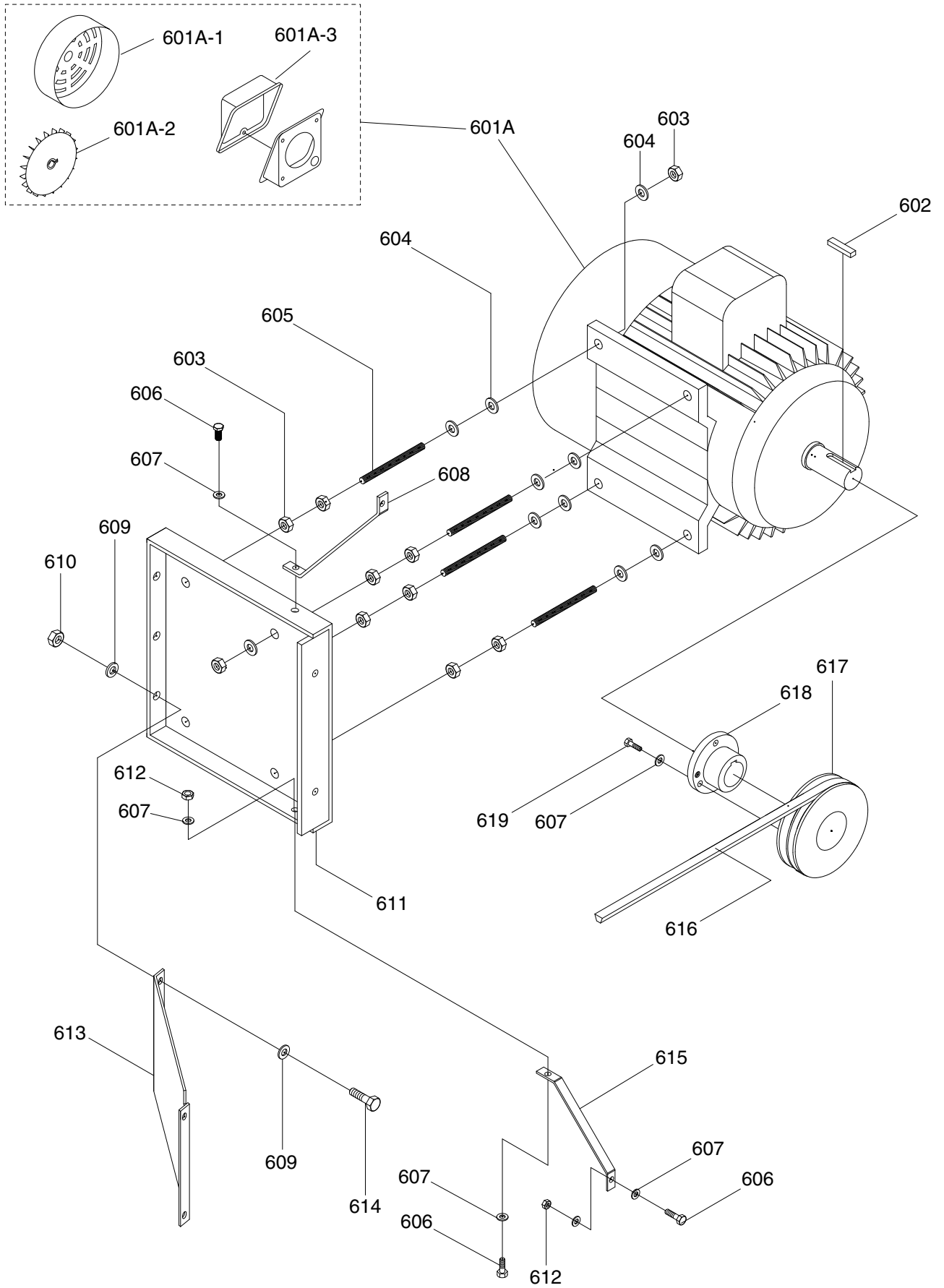


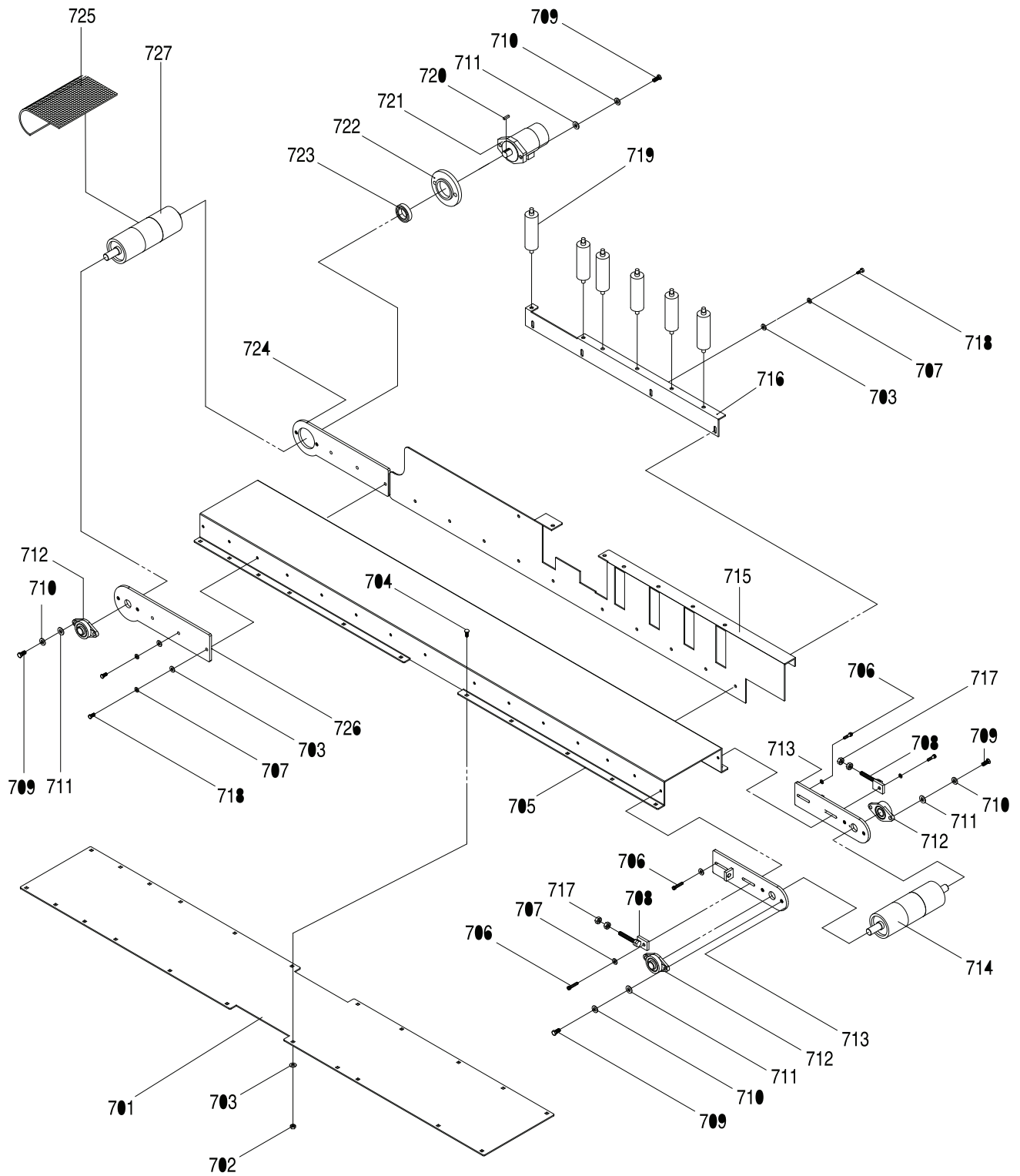


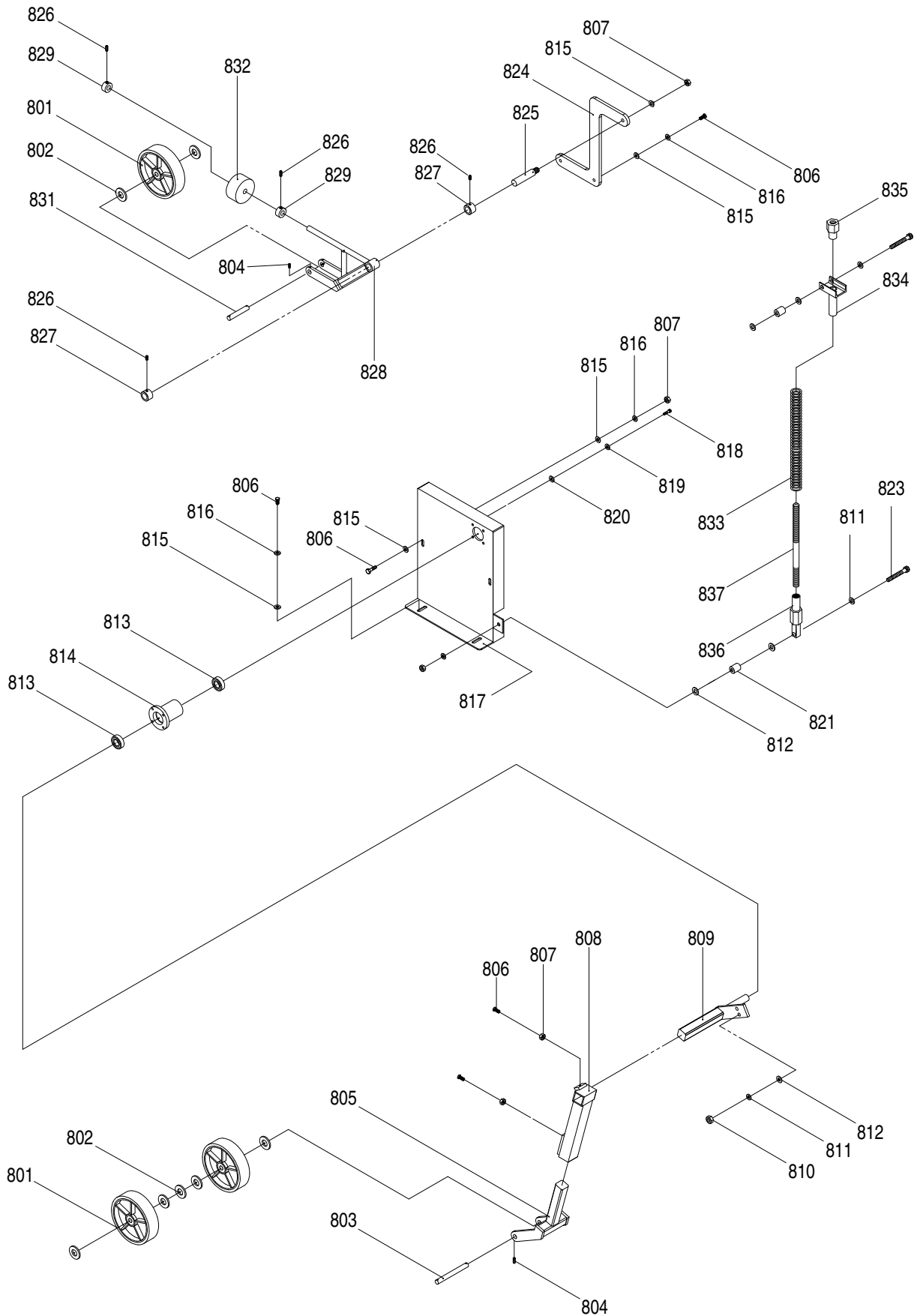


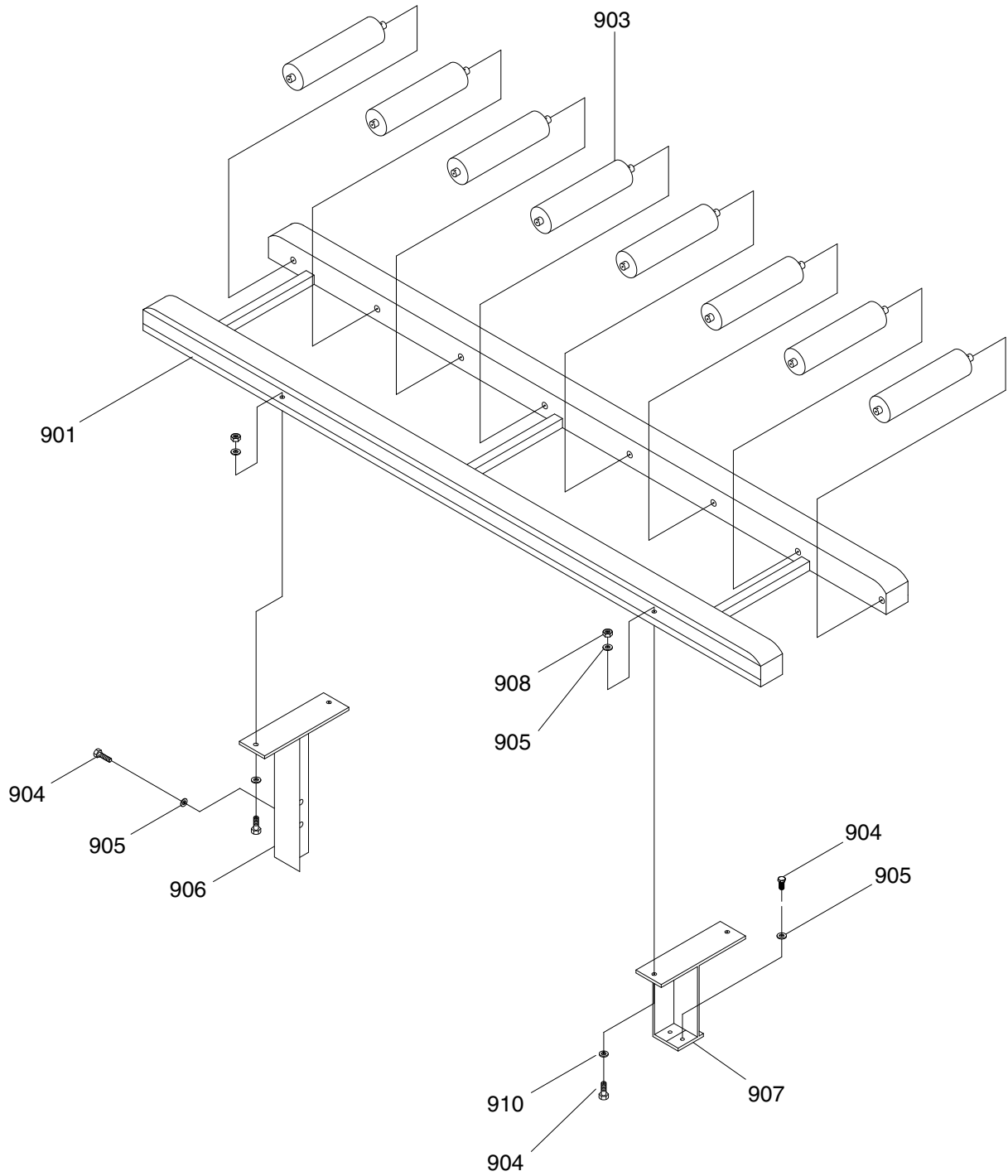


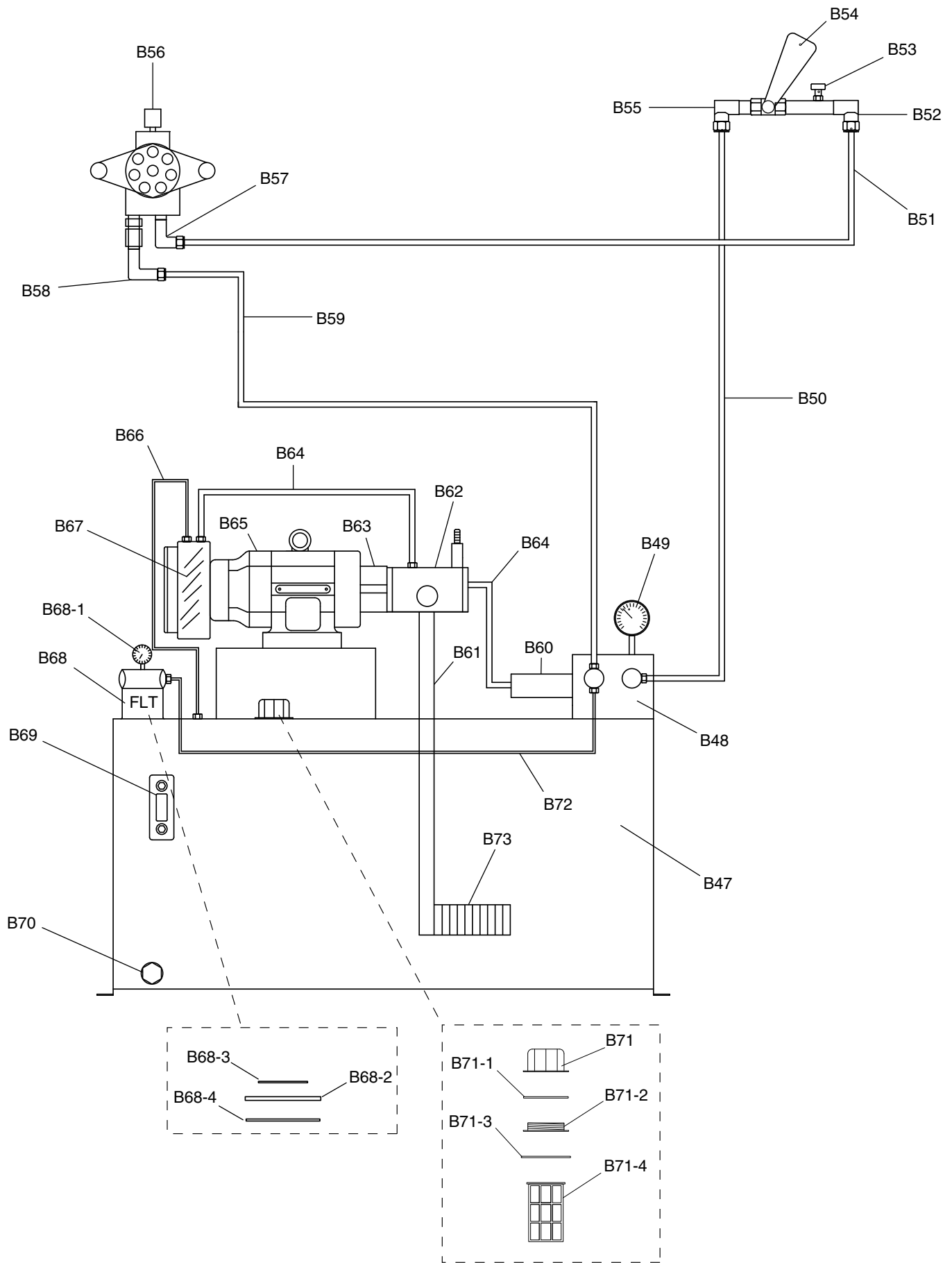
Motor Components

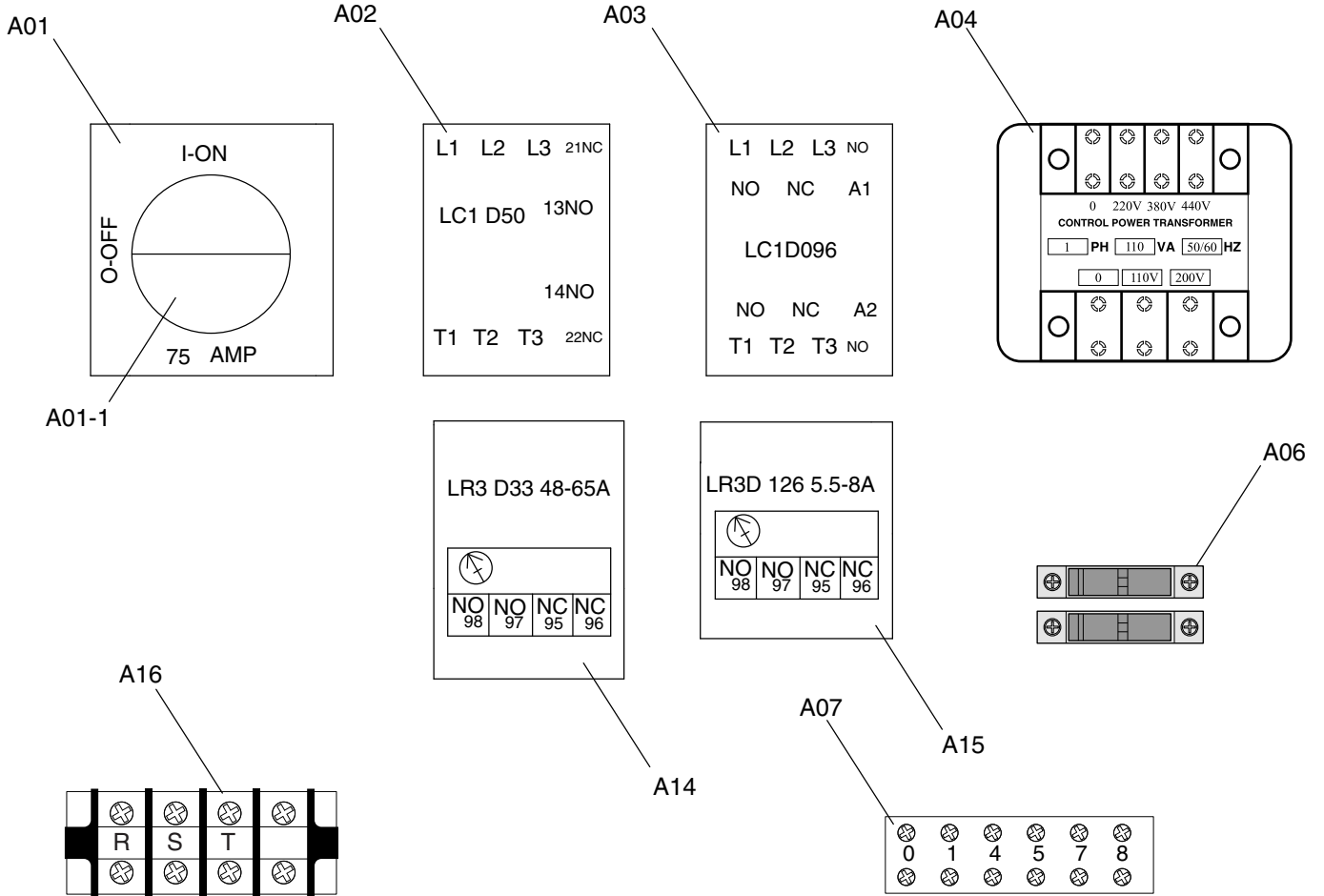
















| REF | PART #   | DESCRIPTION             | REF | PART #   | DESCRIPTION                |
|-----|----------|-------------------------|-----|----------|----------------------------|
| 101 | P0503101 | ELECTRIC BOX            | 141 | P0503141 | PLATE                      |
| 102 | PSB11M   | CAP SCREW M8-1.25 X 16  | 201 | P0503201 | TENSION HANDLE M10-1.5     |
| 103 | PLW04M   | LOCK WASHER 8MM         | 202 | PN02M    | HEX NUT M10-1.5            |
| 104 | PSS16M   | SET SCREW M8-1.25 X 10  | 203 | P0503203 | PLATE A                    |
| 105 | P0503105 | GEAR WHEEL M2.5 X 25T   | 204 | P0503204 | BEARING 51204              |
| 106 | P0503106 | GEAR WHEEL M2.5 X 25T   | 205 | P0503205 | LOCK COLLAR                |
| 107 | P1066079 | BEARING UCP-204         | 206 | P0503206 | STUD M10-1.5 X 200         |
| 108 | PSB36M   | CAP SCREW M12-1.75 X 25 | 207 | P0503207 | PLASTIC SLEEVE             |
| 109 | PLW05M   | LOCK WASHER 12MM        | 208 | P0503208 | COMPRESSION SPR TB-60-090  |
| 110 | PW06M    | FLAT WASHER 12MM        | 209 | P0503209 | FRAME SUPPORT SHAFT(A)     |
| 111 | P0503111 | CONNECT ROD             | 210 | P0503210 | SAW BLADE TENSION ROD      |
| 112 | P0503112 | HANDWHEEL               | 211 | P0503211 | PRESSURE BAR BRACKET       |
| 113 | P0503113 | HANDLE M12-1.75 X 20    | 212 | PSB77M   | CAP SCREW M12-1.75 X 30    |
| 114 | PW06M    | FLAT WASHER 12MM        | 213 | PLW05M   | LOCK WASHER 12MM           |
| 115 | PN02M    | HEX NUT M10-1.5         | 214 | PW06M    | FLAT WASHER 12MM           |
| 116 | P0503116 | FRAME                   | 215 | P0503215 | FRAME SUPPORT SHAFT(B)     |
| 117 | PB01M    | HEX BOLT M10-1.5 X 30   | 216 | P0503216 | PRESSURE BAR NUT           |
| 118 | PLW06M   | LOCK WASHER 10MM        | 217 | P0503217 | ROD END CLEVIS             |
| 119 | P0503119 | PLASTIC WASHER 12MM     | 218 | PB07M    | HEX BOLT M8-1.25 X 25      |
| 120 | PSB64M   | CAP SCREW M10-1.5 X 25  | 219 | P0503219 | CLEVIS PIN 15 X 50MM       |
| 121 | P0503121 | CONTROL PANEL BRACKET   | 220 | PN03M    | HEX NUT M8-1.25            |
| 122 | PSB31M   | CAP SCREW M8-1.25 X 25  | 221 | PLW04M   | LOCK WASHER 8MM            |
| 123 | P0503123 | CONTROL PANEL SUPPORT   | 222 | PW01M    | FLAT WASHER 8MM            |
| 124 | P0503124 | CONTROL PANEL           | 223 | PCB24M   | CARRIAGE BOLT M10-1.5 X 30 |
| 125 | P0503125 | CONTROL BOX             | 224 | PN09M    | HEX NUT M12-1.75           |
| 126 | P0503126 | SLIP SLEEVE SET ROD     | 225 | P0503225 | BEAM                       |
| 127 | P0503127 | CLAMP                   | 226 | PSB72M   | CAP SCREW M10-1.5 X 30     |
| 128 | P0503128 | DUST GUARD BELLOW       | 227 | PLW06M   | LOCK WASHER 10MM           |
| 129 | PSB92M   | CAP SCREW M12-1.75 X 40 | 228 | PW04M    | FLAT WASHER 10MM           |
| 130 | P0503130 | PLATE                   | 229 | P0503229 | BEAM SUPPORT BAR           |
| 131 | P0503131 | SCREW BASE              | 230 | PN09M    | HEX NUT M12-1.75           |
| 132 | P0503132 | WORM GEAR               | 231 | PB63     | HEX BOLT 3/4-10 X 3        |
| 133 | P0503133 | ADJUSTING NUT           | 232 | PLW10    | LOCK WASHER 3/4            |
| 134 | P0503134 | FIXED SCREW BASE        | 233 | PW13     | FLAT WASHER 3/4            |
| 135 | PK33M    | KEY 5 X 5 X 45          | 234 | PCB21M   | CARRIAGE BLT M12-1.75 X 40 |
| 136 | P0503136 | SHAFT COUPLING          | 235 | P0503235 | BEAM PLATE                 |
| 137 | P0503137 | CONNECTOR ROD           | 248 | P0503248 | PLATE B                    |
| 138 | PB09M    | HEX BOLT M8-1.25 X 20   | 301 | P0503301 | RIGHT DOOR                 |
| 139 | PW01M    | FLAT WASHER 8MM         | 302 | PB08M    | HEX BOLT M6-1 X 20         |
| 140 | P0503140 | BRACKET                 | 303 | PW03M    | FLAT WASHER 6MM            |

| REF | PART #   | DESCRIPTION               | REF | PART #   | DESCRIPTION                |
|-----|----------|---------------------------|-----|----------|----------------------------|
| 304 | P0503304 | LOWER HINGE               | 417 | PCB24M   | CARRIAGE BOLT M10-1.5 X 30 |
| 305 | P0503305 | BOTTOM COVER              | 418 | P0503418 | BLADE GUIDE RIGHT ADJ      |
| 306 | PFH02M   | FLAT HD SCR M6-1 X 12     | 419 | PW06M    | FLAT WASHER 12MM           |
| 307 | P0503307 | MAGNET                    | 420 | PN09M    | HEX NUT M12-1.75           |
| 308 | P0503308 | UPPER HINGE               | 421 | P0503421 | BLADE GUARD LEFT SUPPORT   |
| 309 | PCB22M   | CARRIAGE BOLT M6-1 X 16   | 422 | P0503422 | BLADE GUIDE LEFT BRACKET   |
| 310 | PN01M    | HEX NUT M6-1              | 423 | PW04M    | FLAT WASHER 10MM           |
| 311 | PN09M    | HEX NUT M12-1.75          | 424 | PLW06M   | LOCK WASHER 10MM           |
| 312 | PW06M    | FLAT WASHER 12MM          | 425 | PCB21M   | CARRIAGE BLT M12-1.75 X 40 |
| 316 | P0503316 | STAR KNOB M10-1.5 X 25    | 426 | P0503426 | BLADE GUIDE LEFT ADJUSTER  |
| 317 | P0503317 | LEFT UPPER COVER          | 501 | P0503501 | WHEEL ADJ LOWER PLATE      |
| 318 | P0503318 | STAR KNOB M8-1.25 X 20    | 502 | PW13     | FLAT WASHER 3/4            |
| 319 | PN03M    | HEX NUT M8-1.25           | 503 | PB27M    | HEX BOLT M12-1.75 X 30     |
| 320 | P0503320 | SAFETY PLATE              | 504 | P0503504 | WHEEL ADJUSTMENT PIECE     |
| 321 | P0503321 | SAFETY PLATE SUPPORT      | 505 | PSB72M   | CAP SCREW M10-1.5 X 30     |
| 322 | P0503322 | LEFT DOOR                 | 506 | P0503506 | WHEEL ADJ UPPER PLATE      |
| 323 | P0503323 | DOOR LOWER GUARD          | 507 | PN09M    | HEX NUT M12-1.75           |
| 324 | P0503324 | LATCH SET                 | 508 | PB33M    | HEX BOLT M12-1.75 X 50     |
| 325 | P0503325 | LATCH                     | 509 | P0503509 | RIGHT WHEEL SHAFT          |
| 326 | P0503326 | SAFETY COVER              | 510 | P0503510 | INT RETAINING RING 90MM    |
| 327 | P0503327 | RIGHT UPPER COVER         | 511 | P0503511 | SEAL 70 X 90 X 8           |
| 328 | P0503328 | CONNECTOR PLATE           | 512 | P32011   | BEARING 32011              |
| 329 | P0503329 | BOTTOM PLATE              | 513 | P0503513 | DRIVE PULLEY               |
| 330 | P0503330 | DUST GUIDE PLATE          | 514 | P0503514 | SAW BLADE                  |
| 401 | P0503401 | SUPPORT ROLLER            | 515 | P0503515 | DRIVE WHEEL                |
| 402 | P6200    | BALL BEARING 6200         | 516 | PLW05M   | LOCK WASHER 12MM           |
| 403 | PR35M    | INT RETAINING RING 30MM   | 517 | PSB92M   | CAP SCREW M12-1.75 X 40    |
| 404 | P0503404 | ECCENTRIC SHAFT           | 518 | P0503518 | WHEEL SHAFT NUT            |
| 405 | PFH12M   | FLAT HD SCR M6-1 X 25     | 519 | P0503519 | BEARING NUT                |
| 406 | P0503406 | BLADE GUARD UPPER PLATE   | 520 | P0503520 | GREASE FITTING             |
| 407 | P0503407 | SPACER                    | 521 | P0503521 | STUD M12-1.75 X 200        |
| 408 | P0503408 | BLADE GUARD LOWER PLATE   | 522 | P0503522 | SCRAPER                    |
| 409 | P0503409 | LOWER SPACER              | 523 | P0503523 | SCRAPER BRACKET A          |
| 410 | P0503410 | BLADE GUIDE RIGHT SUPPORT | 524 | P0503524 | SCRAPER BRACKET B          |
| 411 | PB07M    | HEX BOLT M8-1.25 X 25     | 525 | PN02M    | HEX NUT M10-1.5            |
| 412 | P0503412 | BLADE GUIDE RIGHT BRACKET | 526 | P0503526 | SCRAPER SUPPORT            |
| 413 | PW01M    | FLAT WASHER 8MM           | 527 | PN03M    | HEX NUT M8-1.25            |
| 414 | PLW04M   | LOCK WASHER 8MM           | 528 | PB82M    | HEX BOLT M8-1.25 X 80      |
| 415 | PN02M    | HEX NUT M10-1.5           | 529 | PB13M    | HEX BOLT M10-1.5 X 80      |
| 416 | PB32M    | HEX BOLT M10-1.5 X 25     | 530 | P0503530 | LINER GUIDE                |

| REF    | PART #      | DESCRIPTION                 | REF | PART #   | DESCRIPTION                 |
|--------|-------------|-----------------------------|-----|----------|-----------------------------|
| 531    | P0503531    | LINER WAY                   | 710 | PLW05M   | LOCK WASHER 12MM            |
| 532    | PLW04M      | LOCK WASHER 8MM             | 711 | PW06M    | FLAT WASHER 12MM            |
| 533    | PSB31M      | CAP SCREW M8-1.25 X 25      | 712 | P1066079 | FLANGE BEARING UCFL205      |
| 534    | P0503534    | BLADE TENSION PLATE         | 713 | P0503713 | ROLLER BRACKET              |
| 535    | PSB14M      | CAP SCREW M8-1.25 X 20      | 714 | P0503714 | FRONT ROLLER                |
| 536    | P0503536    | LEFT WHEEL SHAFT            | 715 | P0503715 | ROLLER SIDE PLATE           |
| 537    | P0503537    | LEFT SAW WHEEL              | 716 | P0503716 | ROLLER SEAT                 |
| 538    | P0503538    | WHEEL BEARING CAP           | 717 | PN09M    | HEX NUT M12-1.75            |
| 539    | PB34M       | HEX BOLT M10-1.5 X 60       | 718 | PB32M    | HEX BOLT M10-1.5 X 25       |
| 601A   | P0503601A   | MOTOR SIEMENS 20HP V2.11.07 | 719 | P0503719 | ROLLER                      |
| 601A-1 | P0503601A-1 | FAN COVER V2.11.07          | 720 | P0503720 | KEY 6 X 5 X 32              |
| 601A-2 | P0503601A-2 | FAN V2.11.07                | 721 | P0503721 | HYDRAULIC DRIVE             |
| 601A-3 | P0503601A-3 | MOTOR WIRING BOX V2.11.07   | 722 | P0503722 | HYD DRIVE FLANGE 6 X 5 X 32 |
| 602    | P0503602    | KEY 9 X 14 X 80             | 723 | P6008    | BALL BEARING 6008           |
| 603    | PN09M       | HEX NUT M12-1.75            | 724 | P0503724 | ROLLER BRACKET              |
| 604    | PW06M       | FLAT WASHER 12MM            | 725 | P0503725 | CONVEYOR                    |
| 605    | P0503605    | STUD M12-1.75 X 110         | 726 | P0503726 | ROLLER BRACKET              |
| 606    | PB09M       | HEX BOLT M8-1.25 X 20       | 727 | P0503727 | REAR ROLLER                 |
| 607    | PW01M       | FLAT WASHER 8MM             | 801 | P0503801 | PRESSURE ROLLER WHEEL       |
| 608    | P0503608    | MOTOR BRACKET SUPPORT A     | 802 | P0503802 | FLAT WASHER 18MM            |
| 609    | PLW06M      | LOCK WASHER 10MM            | 803 | P0503803 | ROLLER SHAFT                |
| 610    | PN02M       | HEX NUT M10-1.5             | 804 | PSS26M   | SET SCREW M5-.8 X 6         |
| 611    | P0503611    | MOTOR BASE                  | 805 | P0503805 | FRONT ROLLER BRACKET        |
| 612    | PN03M       | HEX NUT M8-1.25             | 806 | PB32M    | HEX BOLT M10-1.5 X 25       |
| 613    | P0503613    | MOTOR BASE SUPPORT          | 807 | PN02M    | HEX NUT M10-1.5             |
| 614    | PB32M       | HEX BOLT M10-1.5 X 25       | 808 | P0503808 | FRONT ROLLER ADJUSTER       |
| 615    | P0503615    | MOTOR BRACKET SUPPORT B     | 809 | P0503809 | FRONT ROLLER SHAFT          |
| 616    | PVB51       | V-BELT B-51 5L510           | 810 | PN09M    | HEX NUT M12-1.75            |
| 617    | P0503617    | MOTOR PULLEY                | 811 | PLW05M   | LOCK WASHER 12MM            |
| 618    | P0503618    | LOCKING SLEEVE              | 812 | PW06M    | FLAT WASHER 12MM            |
| 619    | PB07M       | HEX BOLT M8-1.25 X 25       | 813 | P6205    | BALL BEARING 6205           |
| 701    | P0503701    | CONVEYOR LOWER PLATE        | 814 | P0503814 | BEARING BRACKET             |
| 702    | PN02M       | HEX NUT M10-1.5             | 815 | PW04M    | FLAT WASHER 10MM            |
| 703    | PW04M       | FLAT WASHER 10MM            | 816 | PLW06M   | LOCK WASHER 10MM            |
| 704    | PCB24M      | CARRIAGE BOLT M10-1.5 X 30  | 817 | P0503817 | FRONT ROLLER SUPPORT        |
| 705    | P0503705    | CONVEYOR PLATEN             | 818 | PSB14M   | CAP SCREW M8-1.25 X 20      |
| 706    | PSB64M      | CAP SCREW M10-1.5 X 25      | 819 | PLW04M   | LOCK WASHER 8MM             |
| 707    | PLW06M      | LOCK WASHER 10MM            | 820 | PW01M    | FLAT WASHER 8MM             |
| 708    | P0503708    | ADJUSTABLE SCREW            | 821 | P0503821 | SPACER                      |
| 709    | PB102M      | HEX BOLT M12-1.75 X 25      | 823 | PSB120M  | CAP SCREW M12-1.75 X 120    |

| REF   | PART #     | DESCRIPTION                | REF   | PART #     | DESCRIPTION                |
|-------|------------|----------------------------|-------|------------|----------------------------|
| 824   | P0503824   | REAR ROLLER ARM BRACKET    | B47   | P0503B47   | HYDRAULIC TANK             |
| 825   | P0503825   | REAR ROLLER ARM SHAFT      | B48   | P0503B48   | OIL DIVERTER               |
| 826   | PSS16M     | SET SCREW M8-1.25 X 10     | B49   | P0503B49   | HYDRAULIC PRESSURE GAUGE   |
| 827   | P0503827   | LOCK COLLAR A              | B50   | P0503B50   | HYDRAULIC HOSE 3/8 X 67"   |
| 828   | P0503828   | REAR ROLLER BRACKET        | B51   | P0503B51   | HYDRAULIC HOSE 3/8 X 91"   |
| 829   | P0503829   | LOCK COLLAR B              | B52   | P0503B52   | MALE ELBOW 3/8T X 3/8H 90° |
| 831   | P0503831   | REAR ROLLER SHAFT          | B53   | P0503B53   | VARIABLE SPEED ADJUSTOR    |
| 832   | P0503832   | COUNTERWEIGHT              | B54   | P0503B54   | 3/8 HYDRAULIC VALVE        |
| 833   | P0503833   | SPRING                     | B55   | P0503B55   | MALE ELBOW 3/8T X 3/8H 90° |
| 834   | P05030834  | UPPER BRACKET              | B56   | P0503B56   | CONVEYOR HYDRAULIC MOTOR   |
| 835   | P0503835   | UPPER NUT                  | B57   | P0503B57   | MALE ELBOW 1/2T X 3/8H 45° |
| 836   | P0503836   | LOWER ADJUSTABLE NUT       | B58   | P0503B58   | MALE ELBOW 1/2T X 3/8H 45° |
| 837   | P0503837   | SHOCK SCREW                | B59   | P0503B59   | HYDRAULIC HOSE 3/8 X 60"   |
| 901   | P0503901   | RETURN CONVEYOR FRAME      | B60   | P0503B60   | 3/8 STOP VALVE             |
| 903   | P0503903   | ROLLER                     | B61   | P0503B61   | HYDRAULIC HOSE 1/2 X 16"   |
| 904   | PB27M      | HEX BOLT M12-1.75 X 30     | B62   | P0503B62   | HYDRAULIC PUMP             |
| 905   | PW06M      | FLAT WASHER 12MM           | B63   | P0503B63   | CONNECTOR                  |
| 906   | P0503906   | CONVEYOR SUPPORT BRACKET   | B64   | P0503B64   | HYDRAULIC HOSE 3/8 X 20"   |
| 907   | P0503907   | CONVEYOR SUPPORT BRACKET   | B65   | P0503B65   | MOTOR 2 HP                 |
| 908   | PN09M      | HEX NUT M12-1.75           | B66   | P0503B66   | BRASS HOSE 3/8             |
| 910   | PLW05M     | LOCK WASHER 12MM           | B67   | P0503B67   | OIL COOLER                 |
| A01   | P0503A01   | BREAKER #30184 3P 75AMP    | B68   | P0503B68   | OIL FILTER                 |
| A01-1 | P0503A01-1 | POWER ON DIAL SWITCH 30184 | B68-1 | P0503B68-1 | FILTER PRESSURE GAUGE      |
| A02A  | P0503A02A  | MOTOR MAG CONTACT LC1-D50  | B68-2 | P0503B68-2 | FILTER BASE                |
| A03   | P0503A03   | PUMP MAG CONTACT LC1-D096  | B68-3 | P0503B68-3 | FILTER O-RING              |
| A04   | P0503A04   | TRANSFORMER 200VA          | B68-4 | P0503B68-4 | FILTER BASE GASKET         |
| A06   | P0503A06   | FUSE 5A                    | B69   | P0503B69   | OIL LEVEL GAUGE            |
| A07   | P0503A07   | BUSS BAR                   | B70   | P0503B70   | PLUG                       |
| A08   | P0503A08   | MOTOR START BUTTON         | B71   | P0503B71   | FILLER CAP                 |
| A09   | P0503A09   | PUMP START BUTTON          | B71-1 | P0503B71-1 | FILLER CAP GASKET          |
| A10   | P0503A10   | POWER ON BUTTON            | B71-2 | P0503B71-2 | FILLER CAP THREAD PIECE    |
| A11   | P0503A11   | MOTOR STOP BUTTON          | B71-3 | P0503B71-3 | THREAD PIECE GASKET        |
| A12   | P0503A12   | PUMP STOP BUTTON           | B71-4 | P0503B71-4 | FILLER SCREEN              |
| A13   | P0503A13   | EMERGENCY STOP BUTTON      | B72   | P0503B72   | BRASS HOSE                 |
| A14   | P0503A14   | RELAY 220V LR3 D3359       | B73   | P0503B73   | TANK SCREEN                |
| A14A  | P0503A14A  | RELAY 440V LR3 D3355       | B74   | P0503B74   | FILTER + O-RING KIT        |
| A15   | P0503A15   | RELAY 220V LR3 D126        | B75   | P0503B75   | OIL COOLER FAN             |
| A15A  | P0503A15A  | RELAY 440V LR3 D086        | B76   | P0503B76   | HYD TANK ACCESS PLATE      |
| A16   | P0503A16   | TERMINAL BLOCK             | B76-1 | P0503B76-1 | ACCESS PLATE GASKET        |
| A17A  | P0503A17A  | 440V CONVERSION KIT        |       |            |                            |

# Troubleshooting

| SYMPTOM  | POSSIBLE CAUSE   | CORRECTIVE ACTION   |
|--|--|---|
| Motor will not start.  | <ol style="list-style-type: none"> <li>1. Low voltage.</li> <li>2. Open circuit in motor or loose connections.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Check power line for proper voltage.</li> <li>2. Inspect all lead connections on motor for loose or open connections</li> </ol>   |
| Motor will not start; fuses or circuit breakers blow.        | <ol style="list-style-type: none"> <li>1. Short circuit in power wires.</li> <li>2. Short circuit in motor or loose connections.</li> <li>3. Circuit or motor overloaded</li> </ol>  | <ol style="list-style-type: none"> <li>1. Inspect wiring for damaged insulation and shorted wires.</li> <li>2. Repair or replace all connections on motor that are loose or shorted or have worn insulation.</li> <li>3. Reduce amperage load on circuit or motor</li> </ol>  |
| Motor overheats.   | <ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Air circulation through motor restricted.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Reduce load on motor.</li> <li>2. Clean out motor to provide normal air circulation.</li> </ol>   |
| Motor stalls (resulting in blown fuses or circuit breakers). | <ol style="list-style-type: none"> <li>1. Short circuit in motor or loose connections.</li> <li>2. Low voltage.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> <li>4. Motor overloaded.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Repair or replace connections on motor that are loose or shorted or have worn insulation.</li> <li>2. Correct the low voltage conditions.</li> <li>3. Install correct fuses or circuit breakers.</li> <li>4. Reduce load on motor.</li> </ol>   |
| Blade runs backwards.  | <ol style="list-style-type: none"> <li>1. Two of the power wires reversed.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Switch two of the power wires at the terminal strip.</li> </ol>   |
| Blade slows when operating.                                  | <ol style="list-style-type: none"> <li>1. Applying too much pressure to workpiece.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Slow down the feed rate.</li> </ol>   |
| Blade slows when cutting and squeals on start-up.            | <ol style="list-style-type: none"> <li>1. V-Belt loose.</li> <li>1. V-Belt worn out.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Tighten V-Belt as instructed on <b>page 48</b>.</li> <li>1. Replace V-Belt as instructed on <b>page 48</b>.</li> </ol>  |
| Excessive vibration.   | <ol style="list-style-type: none"> <li>1. V-Belt worn out.</li> <li>2. Bent or worn out blade.</li> <li>3. Wheel bearings are worn out.</li> <li>4. Wheels are worn out.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Replace V-Belt as instructed on <b>page 48</b>.</li> <li>2. Replace blade as shown on <b>page 22</b>.</li> <li>3. Replace wheel bearings.</li> <li>4. Replace wheels.</li> </ol>  |
| Conveyor will not run.                                       | <ol style="list-style-type: none"> <li>1. Hydraulic motor is not running.</li> <li>2. Low on hydraulic fluid.</li> <li>3. Hydraulic lines are attached backwards.</li> </ol>   | <ol style="list-style-type: none"> <li>1. See motor troubleshooting above.</li> <li>2. Fix any leaks and add hydraulic fluid.</li> <li>3. Switch hydraulic lines.</li> </ol>  |
| Conveyor runs slow.  | <ol style="list-style-type: none"> <li>1. Too much resistance because of a dull blade on resaw, or an extremely heavy workpiece.</li> <li>2. Restricted line or bad hydraulic motor.</li> <li>3. Hydraulic fluid too cold.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Replace the blade on the resaw, or remove the extremely heavy workpiece.</li> <li>2. Replace hydraulic line or motor.</li> <li>3. Warm up hydraulic fluid or replace fluid with ISO VG 68 hydraulic fluid.</li> </ol>   |
| Hydraulic fluid is overheating.                              | <ol style="list-style-type: none"> <li>1. Oil cooler fins are dirty.</li> <li>2. Restricted flow through the oil cooler.</li> <li>3. Cooling fan not working.</li> <li>4. Overworked system.</li> <li>5. Low on hydraulic fluid.</li> <li>6. Restricted hydraulic line.</li> <li>7. Clogged filter.</li> </ol> | <ol style="list-style-type: none"> <li>1. Clean fins.</li> <li>2. Replace oil cooler.</li> <li>3. Repair cooling fan.</li> <li>4. Reduce load on conveyor belt.</li> <li>5. Fix any leaks and add hydraulic fluid.</li> <li>6. Remove any pinch or kink in the hydraulic line.</li> <li>7. Replace filter and perform a hydraulic system minor service as described on <b>page 37</b>.</li> </ol> |
| Hydraulic fluid looks milky.                                 | <ol style="list-style-type: none"> <li>1. Water in the hydraulic system.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Replace the tank filler cap, tank gaskets, and repair leaks on the suction side of the hydraulic system. Then perform a hydraulic system major service as described on <b>page 38</b>.</li> </ol>   |
| Hydraulic fluid is dark brown or opaque.                     | <ol style="list-style-type: none"> <li>1. Hydraulic fluid has become overheated and thermal breakdown has occurred.</li> <li>2. Hydraulic fluid is contaminated.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Repair the cause of overheating as described above and then perform a hydraulic system major service as described on <b>page 38</b>.</li> <li>2. Perform a hydraulic system major service as described on <b>page 38</b>.</li> </ol>  |
| Filter gauge is in the red.                                  | <ol style="list-style-type: none"> <li>1. Filter is clogged.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Replace filter and perform a hydraulic system minor service as described on <b>page 37</b>.</li> </ol>  |
| Blade does not run evenly on wheels or runs off.             | <ol style="list-style-type: none"> <li>1. Tracking is not adjusted properly.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Adjust tracking as instructed on <b>page 40</b>.</li> </ol>   |
| Blade does not cut evenly or leaves a rough surface.         | <ol style="list-style-type: none"> <li>1. Blade is not properly tensioned.</li> <li>2. Tooth set is uneven.</li> <li>3. Teeth are sharper on one side than the other.</li> <li>4. Blade has a bad weld, or a crack.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Adjust tension as instructed on <b>page 26</b>.</li> <li>2. Replace blade as shown on <b>page 22</b>.</li> <li>3. Replace blade as shown on <b>page 22</b>.</li> <li>4. Inspect blade and replace as shown on <b>page 22</b> if necessary.</li> </ol>   |
| Blade contacting guides.                                     | <ol style="list-style-type: none"> <li>1. Guides not adjusted correctly.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Adjust guides as shown on <b>page 42</b>.</li> </ol>  |
| Workpiece hangs up on pressure rollers.                      | <ol style="list-style-type: none"> <li>1. Pressure rollers out of adjustment.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Adjust pressure rollers as described on <b>page 29</b>.</li> </ol>  |
| Workpiece is thicker on one side than the other.             | <ol style="list-style-type: none"> <li>1. Conveyor is not level.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Level the conveyor as described on <b>page 44</b>.</li> </ol>   |





# Warranty and Returns

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Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs, alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

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Thank you again for your business and continued support. We hope to serve you again soon.



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